

REMARKS

The office action of April 2, 2004, has been carefully considered.

It is noted that the drawings are objected to under 37 C.F.R. 1.83(a) and 1.84(p)(5).

Claims 2-12 are rejected under 35 U.S.C. 112, first paragraph.

Claims 2-12 are rejected under 35 U.S.C. 112, second paragraph.

In connection with the Examiner's objections to the drawings, applicant has amended the specification to include the reference numeral 24 which indicates the controllable power supply. The electrostrictive element is shown in Fig. 5 of the application as with the reference numeral 12 as an electrode made of a piezoelectric material. The paragraph beginning on line 6 of page 12 of the application clearly states that the term "electrostrictive elements" refers to all components that reversibly change a body dimension upon supplying an electric

voltage, such as a piezoelectric component. Thus, it is submitted that an electrostrictive element is shown in the drawings.

In view of these considerations it is respectfully submitted that the objections to the drawings are overcome and should be withdrawn.

In view of the Examiner's rejections of the claims, applicant has amended claim 12.

It is respectfully submitted that the claims presently on file contain subject matter which is sufficiently described in the specification so as to enable one skilled in the art to make and/or use the invention. The specifics of the electrostrictive element are not needed in the application for a thorough understanding of the invention by one skilled in the art since electrostrictive elements are known in the art as evidenced by the six (6) documents attached to this amendment. All these documents either articles on or product manuals for electrostrictive elements, namely piezoelectric sensors, piezo-film sensors and ferroelectric materials for sensors. As mentioned in the specification of the present application on page 12, it is known that these types of materials are electrostrictive. Thus, it is

respectfully submitted that the disclosure is enabling for the electrostrictive element recited in the claims. Also, the electrostrictive element connected to a second circuit is shown in Fig. 5 and discussed in the paragraph beginning on line 12 of page 17 of the specification of the present application.

In view of these considerations it is respectfully submitted that the rejection of claims 2-12 under 35 U.S.C. 112, first paragraph is overcome and should be withdrawn.

It is further respectfully submitted that the claims presently on file particularly point out and distinctly claim the subject matter which applicant regards as the invention. Applicants could not find the passage cited by the Examiner on page 12, lines 19-20. In applicants copy of the application as filed there are only 15 lines on page 12. The Examiner apparently was referring to page 11. In any event, applicant submits that the description of the invention is definite. The paragraph beginning on line 9 of page 11 states that the change in the inner geometry of the transducer or the capsule can be realized by electrostrictive elements. The paragraph goes on to state that "the dimensional changes of the electrostrictive or magnetostrictive elements result in changes in the inner geometry

of the capsule or the transducer". Please note that the change in the inner geometry refers to the transducer, not the electrostrictive element. It is the dimensional changes in the electrostrictive element that causes the changes in the inner geometry of the transducer. This change in the inner geometry of the transducer is described in the paragraph beginning on line 18 of page 11 as a change of the spacing between the electrode and the diaphragm. Applicant has amended claim 12 to clarify this.

In view of these considerations it is respectfully submitted that the rejection of claims 2-12 under 35 U.S.C. 112, second paragraph is overcome and should be withdrawn.

Reconsideration and allowance of the present application are respectfully requested.

Any additional fees or charges required at this time in connection with this application may be charged to Patent and Trademark Office Deposit Account No. 11-1835.



BP-65

Respectfully submitted,

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Dated: November 2, 2004

CERTIFICATE OF MAILING

I hereby certify that this correspondence is being deposited with the United States Postal Service as first class mail in an envelope addressed to: Commissioner for Patents, PO Box 1450 Alexandria, VA 22313-1450, on November 2, 2004.

By: *F. Kueffner*
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Date: November 2, 2004

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ATOC

PIEZO FILM SENSORS

J.VICTOR CHATIGNY AND LESTER E. ROBB, PENNWALT CORPORATION

More than 100 years ago, Jacques and Pierre Curie discovered that quartz crystals produced an electrical charge when deformed. They also found that the same crystals changed in dimension when subjected to an electric field. They called this phenomenon "piezo electricity"—derived from the Greek for 'pressure electricity.' Not long after, the same crystals were found to develop a similar charge when exposed to incident thermal radiation, and the term "pyroelectricity" was coined. A clear definition of these terms proposed by W. G. Cady (1) is as follows:

- **Piezoelectricity** is electric polarization produced by mechanical strain in certain crystals, the polarization being proportional to the amount of strain and changing sign with it. The reverse is also true: an electrical polarization will induce a mechanical strain in piezoelectric crystals.
- **Pyroelectricity** is electric polarization induced by thermal absorption in certain crystals, the polarization being proportional to the level of thermal change.

This article will explain piezoelectricity in polyvinylidene fluoride (PVDF) and discuss the function of piezo film sensors in a number of industrial, medical, and military devices.

PROPERTIES OF PVDF AND PIEZO FILM

Polyvinylidene fluoride (2) is a long chain semicrystalline polymer of the repeat unit ($\text{CH}_2\text{-CF}_2$). The monomer, vinylidene fluoride, $\text{CH}_2=\text{CF}_2$, has a large dipole moment, about 7.56×10^{-30} Cm. The monomer units polymerize in an orderly fashion to produce greater than 90 percent head-to-tail configuration; i.e. $-\text{CH}_2-\text{CF}_2-\text{CH}_2-\text{CF}_2-$. Thus, the polymer exhibits an unusually high net dipole moment.

The properties of PVDF, including piezoelectricity, are highly influenced by the degree and type of crystalline structure. There are at least three distinct crystalline forms. The most common—and the one obtained when the polymer is cooled from its melt—is the nonpolar, centrosymmetric unit cell called the alpha phase. Deformation of alpha-type crystallites, such as the stretching of extruded film at temperatures below 80°C , causes a packing of unit cells in parallel planes to produce the polar beta phase. A third configuration is the gamma phase, which, while polar, is intermediate in terms of centrosymmetry between alpha and beta phase configurations.

Mechanical orientation of gamma phase polymer also yields beta phase crystallites. To obtain significant piezoelectric and pyroelectric activities, beta phase polymer must be "poled," a term used for exposing the polymer to an electric field of 500-1000 kV/cm at elevated temperatures (80-110°C). The level of piezo activity so obtained depends upon poling time, field strength, and temperature. When conducted properly, the poling process provides for a permanent orientation of molecular dipoles within the polymer.

Thus, a typical process for preparing piezo film can be summarized as follows:

- Extrusion of PVDF pellets into alpha phase film
- Orientation, either uniaxially or biaxially, at 80°C and at a stretch ration of 4-5 to produce beta phase film
- Electrode deposition by one of various methods
- Thermal poling at 600kV/cm at 100°C for 30 min.

During the poling process, the dipoles are aligned relative to the direction of the poling field. When piezo film is operating in an electromechanical or motor mode, the film elongates and contracts as the polarity of the alternating field changes. When operating in a mechanoelectrical or generator mode, external forces are applied that produce compressive and tensile strain. These deformations cause a change in the surface charge density, resulting in a voltage between the electrodes, whose polarity changes as the direction of force is reversed.

It is important to consider piezo film as a dynamic material that develops an electrical charge proportional to the change in mechanical stress. It does not operate in a static condition because of the rapid decay of the induced charge. Its time constant is determined by the film's dielectric constant and internal resistance, as well as by the impedance of connected circuits.

Pyroelectric action of piezo film is used to detect thermal radiation (3). When thermal energy is absorbed, the corresponding rise in film temperature alters the charge density and produces a detectable voltage output. This pyroelectric action is reversed upon cooling.

Piezoelectric materials are anisotropic—their electrical, mechanical, and electromechanical properties differ for electrical or mechanical excitation along different axes. This anisotropy can be used to advantage in common mode reflection and signal isolation design.

For a systematic tabulation of properties, the axes are identified by numerals: "1" corresponds to length; "2" corresponds to width; and "3" corresponds to thickness. For most properties, two numerical subscripts are used. The first identifies the axis of polarization or applied electrical field. The second numeral refers to the axis of mechanical strain or applied stress.

Positive mechanical action is defined as tensile, while negative action is compressive. Positive electrical action is that causing an increase in polarization and vice versa. For piezo film, the polarization axis is

always the thickness, or "3," axis because the field is aligned in that direction. Mechanical stress or strain can be applied to all three directions. For uniaxially stretched film, the direction of stretch becomes the length, or "1," axis.

The following constants are often employed for characterizing the activity of piezo active materials.

- **Coupling Constant "K."** Coupling expresses the ability to exchange electrical energy for mechanical energy and vice versa. The square of the coupling constant "K" equals the transformed energy divided by total energy input. Thus $K_{31}^2 = (\text{transformed electrical energy causing mechanical strain along the "1" axis}) / (\text{total electrical energy to electroded faces parallel to the "3" axis})$.
- **Piezoelectric Strain Constant "d".** The "d" constant expresses the ratio of strain developed along a specific axis to the field applied parallel to a specified axis. The "d" constant also expresses the ratio of short circuit charge per unit area of electrodes perpendicular to a specified axis to the stress applied along the same or other specified axis to the stress applied along the same or other specified axis. Thus:

$$d_{31} = \frac{\text{Strain in "1" axis}}{\text{Applied field in "3" axis}} = \frac{\text{m/m}}{\text{V/m}} = \frac{\text{m}}{\text{V}} \quad (1)$$

also,

$$d_{31} = \frac{\text{Charge per electrode area}}{\text{Applied stress in "1" axis}} = \frac{\text{C/m}^2}{\text{N/m}^2} = \frac{\text{C}}{\text{N}} \quad (2)$$

- **Piezoelectric Stress Constant "g".** The "g" constant expresses the ratio of the electric field along a specified axis to the stress applied to the same or other specified axis. The "g" constant also expresses the strain along a specific axis to the electrical charge per unit area of electrodes. Thus:

$$g_{31} = \frac{\text{Applied electric field "3" axis}}{\text{Stress applied along "1" axis}} = \frac{\text{V/m}}{\text{N/m}^2} = \frac{\text{V}\cdot\text{m}}{\text{N}} \quad (3)$$

also,

$$g_{31} = \frac{\text{Strain along "1" axis}}{\text{Charge per electrode area}} = \frac{\text{m/m}}{\text{C/m}^2} = \frac{\text{m}^2}{\text{C}} \quad (4)$$

- **Piezoelectric Hydrostatic Constant "d_h".** The "d_h" constant is the ratio of short circuit charge per unit area of electrode surface to the hydrostatic stress applied equally along all three axes.
- **Pyroelectric Constant "p".** Pyroelectric transducers absorb thermal energy, thereby raising their temperatures and inducing electrical signals. In piezo film, the output signal is proportional to the rate of temperature change rather than temperature levels. The pyroelectric constant "p" relates the charge per unit area of film electrodes per unit change of temperature. Thus,

$$p = \text{C/m}^2 \cdot ^\circ\text{K}.$$

Many properties of piezo film vary with changes in frequency and

temperature. The film's dependence of temperature is shown in Figure 1. The decay of the piezoelectric strain constant " d_{33} " while negligible at 22°C, increases to 30 percent at 80°C. After exhibiting an initial decay, the activities tend to remain constant with time. Thermal treatment or annealing of the film minimizes long-term aging.

Table 1
Typical Properties of Piezo Film

t	Thickness	9, 28, 52, 110, 220, 800 $\times 10^{-6}$ meter (μm)
d_{31}	Piezoelectric Strain Constant	$23 \times 10^{-12} \frac{\text{m/m}}{\text{V/m}}$ or $\frac{\text{C/m}}{\text{N/m}}$
d_{33}	Constant	$-33 \times 10^{-12} \frac{\text{m/m}}{\text{V/m}}$ or $\frac{\text{C/m}}{\text{N/m}}$
g_{31}	Piezoelectric Stress Constant	$216 \times 10^{-3} \frac{\text{V/m}}{\text{N/m}^2}$ or $\frac{\text{m/m}}{\text{C/m}^2}$
g_{33}	Constant	$-339 \times 10^{-3} \frac{\text{V/m}}{\text{N/m}^2}$ or $\frac{\text{m/m}}{\text{C/m}^2}$
K_{31}	Electromechanical Coupling Factor	12 % (@ 1kHz)
K_{33}	Coupling Factor	19 % (@ 1kHz)
C	Capacitance	380 pF/cm ² for 28 μm film $\epsilon/\epsilon_0 = 12$
Y	Young's Modulus	$2 \times 10^9 \text{ N/m}^2$
c_v	Speed of Sound	$1.5 - 2.2 \times 10^3 \text{ m/s}$ (transverse thickness)
p	Pyroelectric Coefficient	$-25 \times 10^{-6} \text{ C/m}^2\text{K}$
ϵ	Permittivity	$106 - 113 \times 10^{-12} \text{ F/m}$
ϵ/ϵ_0	Relative Permittivity	12 - 13
ρ_m	Mass Density	$1.78 \times 10^3 \text{ kg/m}^3$
ρ_e	Volume Resistivity	$10^{13} \text{ ohm meters}$
R_{\square}	Surface Metallization Resistivity	1 ohm/square for Al 10 ohms/square for Ni 0.1 ohms/square for Ag ink
$\tan \delta_e$	Loss Tangent	0.015 - .02 (@ 10 - 10^4 Hz)
	Compressive Strength	$60 \times 10^6 \text{ N/m}^2$
	Tensile Strength MD	$160 - 300 \times 10^6 \text{ N/m}^2$
	TD	$30 - 55 \times 10^6 \text{ N/m}^2$
	Temperature Range	-40°C to 80°C
	Water Absorption	0.02 % H ₂ O
	Max Operating Voltage	750 V/mil = 30 V/ μm
	Breakdown Voltage	2000 V/mil = 100 V/ μm

In terms of frequency dependence, piezo film is vastly different from ceramic transducers. It has wide-band characteristics (from approximately DC to GHz) and a much lower Q. The flat frequency response over a wide range is due to the polymer's softness, compared to hard, brittle ceramics. The basic resonance of a free-standing sheet of 28 μm piezo film is 40 MGz. Resonance values change with film thickness—from low MHz for thick film (1mm) to GHz for very thin films. A major difference between piezo film and most piezoceramics is the film's low permittivity value of 12 (PZT is 12,000). As a result, the "g" or stress constant, of piezo film is significantly greater. Another key feature is the relatively low acoustic impedance and its close match to those of water, human tissue, and other organic matter.

Table 2
Comparison of Properties of
Piezo and Pyroelectric Materials

Property, units	Piezo Film	PZT	BaTi ₂ O ₃
Density, kg m ⁻³	1.78	7.5	5.7
Relative Dielectric Permittivity	12	1200	1700
"d" Constant, CN ⁻¹ ($\times 10^{-12}$)	23	110	78
"g" Constant, VmN ⁻¹ ($\times 10^{-3}$)	230	10	5.2
"K" Coupling Constant, %	12	30	21
"Z" Acoustic Impedance, kg m ⁻² sec. ⁻¹	2.5	30	30

A close impedance match allows acoustic signals to pass through the film without being distorted. This is significant in many applications, such as the retention of the signal in medical ultrasound. Table 2 compares the key properties of piezo film to those of two important piezoceramics, PZT and BaTi₂O₃.

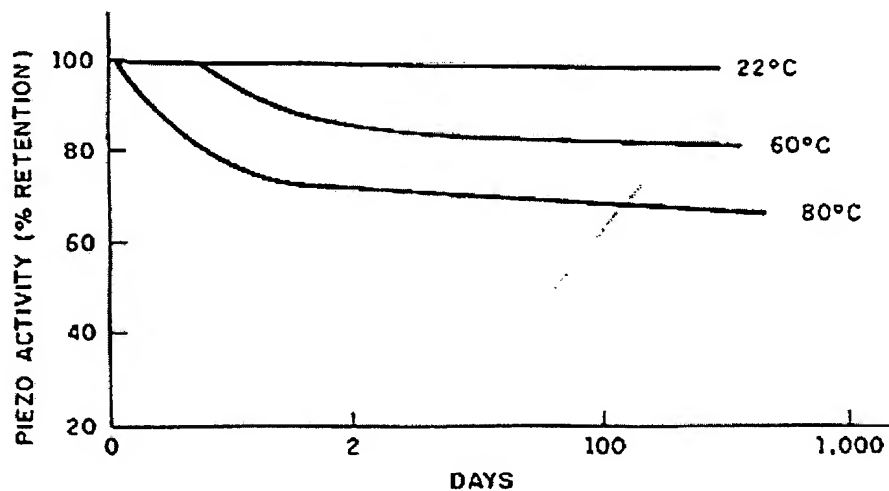


Figure 1. Piezo film is temperature dependent. After the initial decay, piezo activity remains stable over an extended time period.

ADVANTAGES AND DISADVANTAGES

Piezo film is a compliant, lightweight, tough, plastic film available in a wide variety of thicknesses and surface areas. Thus, it is vastly different in physical form from other well-known piezo active materials such as quartz and piezoceramics. What is not so obvious are certain operating advantages and disadvantages between these materials.

• Advantages

- Piezo film operates over an extremely wide frequency range—from the tapping of one's finger on a simple touch panel switch to transducer arrays for ultrasonic imaging that operate in the 1-10 MHz range. IN fact, the film detects GHz frequencies.

- It has a wide dynamic range. This sensitivity for mechanical to electrical conversion has been used to measure the impact of micron particles in space and to monitor the explosive force of an armor-piercing shell (>286 dB range).
- It has low acoustic impedance. Good impedance matching provides for efficient energy transfer necessary in many applications, such as medical ultrasound and hydrophones. Also, it means that many polymer adhesives with similar impedance values can be used in transducer fabrication without causing significant signal distortion.
- It has a higher dielectric strength than piezoceramic material (30 V/μm versus 1.5 V/μm) and therefore can be exposed to higher electric fields.
- Its relatively high "electrical" impedance provides a complementary match to popular high-impedance (CMOS) circuits.
- Because piezo film is a thin, flexible plastic film, its elastic compliance is many times that of piezoceramics. When laminated to a vibrating structure, it does not significantly distort the motion of the structure.
- Because it is a high molecular weight fluoropolymer, it is mechanically strong and able to withstand extreme environmental conditions, including most solvents, acids, oxidants, and intense ultraviolet radiation. Also it is insensitive to highly humid conditions.
- It is easily cut and formed into complex shapes or prepared as a large area transducer. Sections of film can be readily adhered to each other or to other surfaces using commercial adhesives. Also, conductive coatings and a variety of lead attachments are available.
- Material and fabrication costs of piezo film are generally lower than those of other piezo active materials.

● Disadvantages

- Because piezo film is a flexible compliant film, it is not a powerful electromechanical transmitter, particularly at low frequency. Thus, it will not operate well as a low-frequency, large area, acoustic speaker. Not can a compliant film generate the large force required of a powerful electromechanical driver.
- The activity of piezo film decreases at elevated temperatures; therefore, its applications are limited to those operating under 100°C.
- It is sensitive to electromagnetic signals over a wide frequency. For certain applications, it is necessary to carefully shield the hot side of the device from EMI radiation.

APPLICATIONS

Because piezo film is a new form of transducer, many of its markets are developmental. Excellent progress is being made, however, resulting in

improved designs for a number of electromechanical devices. What follows is a summary of the basic principles used for industrial, medical, consumer, and military applications.

- **Switches.** The simplest way for piezo film to act as a switch is to apply a stress to the film and obtain an output signal, its strength being proportional to the applied stress. The piezo film switch operates by developing a charge within the film and transferring it to the outer electrodes; a circuit is not completed from the closure of an electrical contact.

A helpful design factor is to deform the film by stretching it in the length or "l" direction, thereby maximizing the stress (the force acts on the thin film's cross-section) and maximizing the output voltage. This was done by C.T. Pearman and his colleagues at Bell Laboratories (4) who developed a contactless touchtone keyboard. Their pushbutton device consisted of piezo film clamped over a circular cavity; a vertical force (the push button) stretched the film like a drum head. A snap disc was placed in the cavity below the film to provide a pulse nearly independent of the rate of push. Figure 2 shows the output voltage curve measured on a 10 M Ω oscilloscope as the button was pushed and then released. The resultant voltage spikes were 8 to 10 V and of opposite polarity.

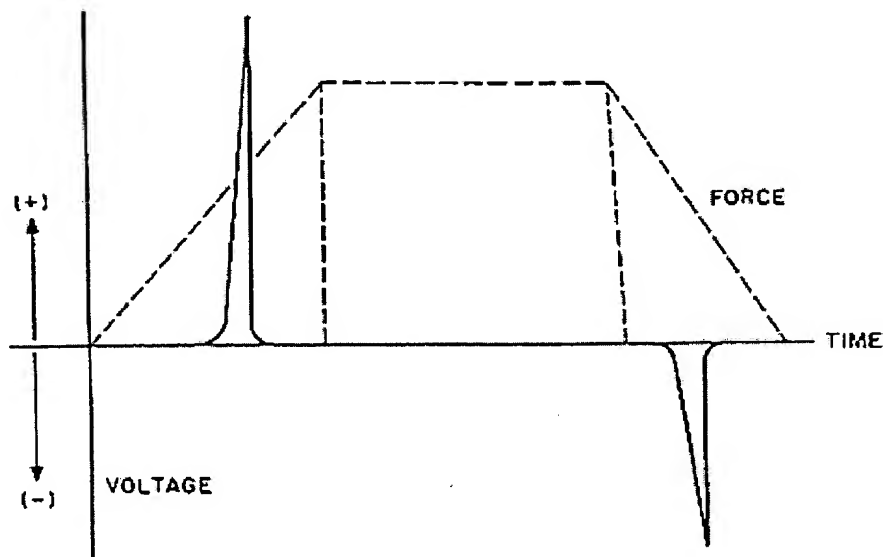


Figure 2. Force input and voltage output profiles are shown for a key as it is pushed and released a peizo film switch. The voltages range from 8 to 10V, and are opposite in polarity.

Keyboards made from multiple switches of this type were life-tested using a push rate of five pushes per second. Seven keyboards containing 19 buttons were pushed 95 million times. No button wear occurred, and greater than 15 million pushes per keyboard were recorded without loss of signal strength. It was Bell Laboratories' conclusion that a piezo film keyboard switch is highly reliable and appears to have unlimited life.

One disadvantage becomes apparent for high-density keyboards having common conductors in rows and columns. Under these conditions, the electrical charge from a piezo film switch is transferred by capacitive coupling to adjacent switches that share common conductor lines, resulting in crosstalk and a decrease in the signal-to-noise ratio. For large arrays, the use of separate conductive paths for each key may not be practical without further signal processing.

One of the promising solutions that involves only a single piezo film is the use of a split-key electrode pattern developed by Toray Industries (5). In this pattern, the signal detecting and ground electrodes are positioned in a way that eliminates capacitive coupling.

- **Computer Graphics.** Somewhat related to switches are devices used in computer graphics and electronic games for X-Y coordinate location. Such a device was developed by the Scottish research firm Syrnix Innovations Ltd. (6). It consisted of a rectangular sheet of glass over which was laid a thin metal sheet containing rows and columns of snap domes that acted as keys. Piezo film strips were attached to all four edges of the glass sheet. When a chosen dome was pressed, it impacted the glass sheet, causing an acoustic wave to radiate at the velocity of sound in glass to all four edges. Receipt of the wave by the piezo film transducers resulted in their respective output signals. The time differences of these signals were processed to give the X-Y coordinates of the point of dome impact. Resolution values of 0.1 mm were obtained with this device. This resolution is the result of the film's high sensitivity as a contact microphone, in this case to distinguish the difference in microseconds of wave travel.
- **Robotic Tactile Sensors.** Market studies (7) show that the largest potential markets for robots lie in assembly tasks, like those in the electronics industry, that require deft touch. With current tactile sensors, the shape of the surface being gripped and the pressure needed to grasp the article can be determined. However, to be truly useful, the sensor must duplicate the human hand with respect to sensing pressure, direction, temperature, vibration, and texture.

A number of researchers have evaluated piezo film in robotic sensors. P. Dorio, et al., at the "Centro per l'Automatica E. Piaggio" in Pisa, Italy (8), constructed a planar matrix of 1 by 16 (256) circular sensors supported on a PCB. As shown in Figure 3, a 100 μ m thick piezo film, fully metalized on the top surface, was glued to the PCB using a nonconductive adhesive. The electrical charge generated by the force exerted in the " d_{33} " mode on the piezo film by the object is collected between the lower electrode on the PCB and the common ground electrode. Individual wires connect each sensor to signal processing units. The program reads the matrix within 50 m/sec. The accuracy of the touch sensor is also shown in Figure 3, where the form of the test object is reproduced together with specific sensor points.

Similar studies have been conducted at Carnegie-Mellon University under M. Siegal. The ultimate objective of such work is a piezo film skin with a dense matrix of sensitive dots that correspond to the nerve center in human fingers.

A different approach to duplicating the touch and feel of skin for tactile sensing was used by A.A. Schoenberg at the University of Utah Research Institute (9). In his configuration (see Figure 4), piezo film is used to transmit and receive ultrasonic waves through a 1.5 mm thick layer of silicone rubber. As force is applied to compress the element, the time-of-flight of the pulse

decreases in proportion to the reduction in layer thickness. By continually monitoring the change in time-of-flight and converting this change to voltage units, an accurate reading of force is recorded. This dynamic approach to tactile sensing proves to be very accurate. In addition, it does not exhibit a pyroelectric response to changes in temperature.

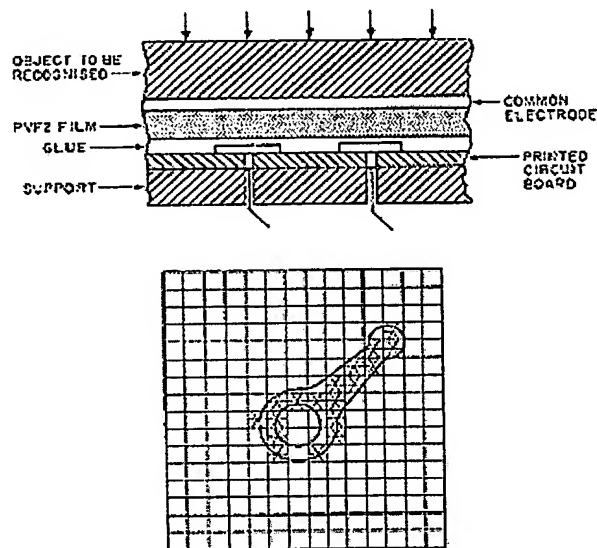


Figure 3. Cross section of P.Dorio planar matrix robotic sensor and reproduction of testing object.

A.R. Grahn and L. Astle of Bonneville Scientific Laboratories

(10) also use the compression of an elastomeric pad to measure force. Their tactile sensor is based on ultrasonic pulse-echo ranging to measure the change in thickness of a silicone rubber pad when its surface is deformed by a gripped object. As indicated in Figure 5, the pad thickness is determined by the time "t" required for an ultrasonic pulse to traverse the pad and return to the transducer film. Using this time interval, and knowing the speed of sound in the pad and the pad's elastic modulus, the force compressing the pad is readily calculated. Piezo film proves to be an excellent transducer for this application because of its conformity and close acoustic match to silicone rubber. These researchers conclude that rugged, inexpensive robotic force arrays are feasible and possess the following characteristics: measurement of force over a 2000:1 range, spatial resolution of forces 0.5 mm apart, and a response time of 5 μ s.

- **Infrared Detectors.** Although its pyroelectric coefficient is lower than that of piezoceramics such as PZT, piezo film exhibits a simplicity in design, ruggedness in operation, ability to be formed into ultra thin sheets for rapid thermal response, and relatively low cost that make piezo film IR detectors highly desirable for many industrial and consumer applications.

For example, piezo film IR detectors are ideal for security systems because they can detect a human body at a distance of 50 ft. Piezo film detectors have also been developed for room energy-management systems, for automatic control of driveway lighting based on IR emitted

by automobile engines, and for the location of "hot spots" behind walls for evidence of fire.

Various methods are used to treat incident IR radiation to optimize detector performance. One approach is to coat the front electrode with an IR absorbant, including certain organic polymers as described in U.S. Patent 4, 379, 971 (11). Also reported in the same patent is the use of multiple electrode patterns designed to cancel extraneous noise, a principle called "common mode rejectoin." In this case, two intermeshing patterns on the front electrode are of opposite polarity and act to nullify any overall thermal effect such as background temperature changes. Movement of an IR source causes the radiation focal point to move across the patterns, generating an alternating output voltage. Thus, the variatoin of voltage and polarity with respect to time determines the relative size and ovement of the IR source.

In another example, an instant medical thermometer has been developed (12) in which the piezo film transducer rapidly measures the difference between ambient and a patient's body temperature. The amplitude of the output voltage spike of the film is compared to an ambient temperature reference and becomes a highly accurate measurement of the patient's body temperature, which can be made in a fraction of a second.

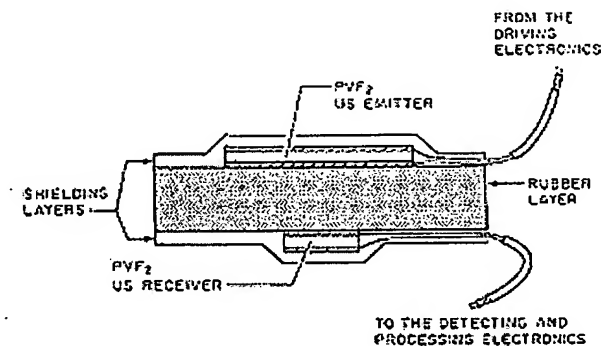


Figure 4. This sketch of the ultrasound tactile sensor developed by A.A. Schoenberg shows that by monitoring the time-of-flight of ultrasonic pulses across the 1.5 mm rubber layer, an accurate reading of the applied force can be made.

- **Medical Sensors.** Much work has been devoted to the improvement of sensors for monitoring biological functions such as respiration and cardiac rhythm.

One interesting medical application of piezo film is a unique flowmeter (13) developed by Perkin-Elmer for use in hospital intensive care and operating rooms to monitor respiration and the application of anesthesia. The heart of the unit is a thinwalled plastic tube whose interior surface is encircled by two torsional shaped piezo film transducers, one at each end of the tube. When energized, the transmitting transducer, vibrating at 40 kHz, couples ultrasonic energy into the gas stream traveling within the tube. Conversely, the ultrasound is coupled from the gas stream by the receiving transducer, resulting in an electrical output signal. The transmitter-reciver roles are exchanged every 5 ms. When a gas in the tube is moving, the time of travel of the sonic waves is altered, becoming shorter or longer depending upon whether the sound moves with or against the patient's breath. The difference between the time of sound

travel with and without the flow of gas is proportional to the gas stream flow rate. This difference is measured every 10 ms and is converted into a gas flow signal.

The reported advantages of this type of flowmeter include no restriction in the tube to cause pressure drop, no need to recalibrate for each type of gas, insensitivity to gas composition, and resistance to chemical attack by oxygen and other gases used in the stream. In addition to the medical field, this device has broad application as a flow monitor for industrial gases and liquids.

- **Musical Instrument Pickup.** An interesting consumer market is developing for high-quality contact microphones or "pickups" for a wide variety of musical instruments. Typical of this device is a piezo film strip transducer for guitars.

The transducer is usually three inches long, one inch wide, and one mil thick. After electrodes are deposited, the strip is shielded on both sides by metallic foil. To protect the film from abrasion, it is encapsulated in a flexible polymer laminate. Finally, it is fitted with a plastic terminal block and standard microphone cable.

Although simple in construction, many tests show this pickup to be truly remarkable in its ability to record and amplify sound at far greater fidelity than is now possible. These pickups can be used on a variety of instruments including guitars, pianos, saxophones, drums, cymbals, accordions, violins, cellos, and percussion instruments of all kinds. The pickup is easily attached to instruments using thin, double-sided plastic tape.

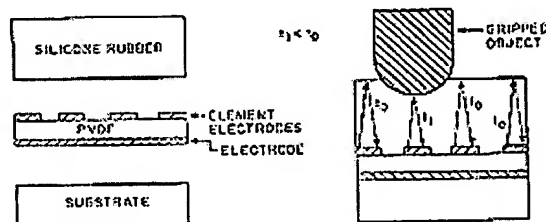


Figure 5. Shown is the array construction and principle of operation of a pulse-echo tactile sensor developed by A.R. Grahn. The force compressing the pad can be calculated by knowing the time "t" required for ultrasonic pulses to cross the pad and return to the transducer elements

Two exciting new developments in musical instruments are the RAAD electric violin and the Gibson J-45 E guitar. To capture its tone, the RAAD violin (14) is constructed from high-quality traditional materials—maple, spruce, and ebony—but an amplification system is also built within the violin that produces total sound without distortion. This system is a piezo film contact microphone. *Frets Magazine* (15) has evaluated the Gibson J-45 E guitar and concluded that the new pickup successfully transformed the guitar into an appealing acoustic-electric instrument with excellent tone. It has the same characteristics—broadband response and distortion-free recording of sound—that make piezo film contact microphones ideal for other applications, such as vibration monitors used to analyze the performance and safety of moving machinery.

- **Hydrophones.** In recent years much work has been directed toward enhancing the performance of sonar devices for both military and commercial applications. One of the most promising advances is the use of large area hydrophone arrays (16) mounted on the hulls of surface craft and submarines.

The potential advantages of such piezo film acoustic receivers over conventional piezoceramic transducers are as follows: piezo film is readily adaptable to large areas, is more flexible and conformable to irregular hull surfaces, has much greater shock resistance, is lighter weight due to lower density and thin shapes, has an acoustic impedance close to that of water, and has a higher hydrostatic stress constant " g_h ," which results in greater acoustic sensitivity. Because it is a compliant material and has a low Q and a low coupling factor " K_{33} " piezo film's utility is limited to use as a receiver. It may be visualized as a huge underwater microphone. More work is needed to improve the transducer's thermal stability and to develop systems that decouple both shipboard and extraneous ocean noises. Recently, Pennwalt reported success in increasing the sensor's thermal stability from 50 to 100°C. The approach involves a change in polymer composition that allows the film to be poled in its relaxed, rather than highly oriented, state and still produce good sensitivity values.

Table 3
List of Piezo Film Applications
According to Market-Product Segments

Military-Government

Hydrophones:	Hull mounted sonar systems Sonobuoys Towed cable arrays Geophysical systems
Fuses:	Impact and Thermal types
Security Systems:	Perimeter control
Aerospace:	Research on space particles
Energy Generation:	Ocean wave Wind power
Acoustic Emission:	Nondestructive testing

Computer (Input-Output)

Keyboards:	Force transducer arrays
Printers:	Impact and Ink jet
X-y Coordinates:	CRT Digitizers Mouse
Copiers:	Switches and Counters

Industrial

Security and Energy Management:	Passive IR detectors
------------------------------------	----------------------

	Vidicon
	Vibration
Robotics:	Tactile sensors
Load Cells:	Consumer bathroom scales
	Industrial scales
Pressure Regulators:	Industrial
Impact/Switch:	Coin sensor
	Glass panel breakage
	Traffic monitors
	Traffic monitors
Flowmeters:	Pumps
	Air condition ducts
Automotive:	Engine knock monitors
	Tire pressure gauge
	Fuel injection control
Fuel tank level gauge	Driving control switches

Instrumentation

Machinery Monitor:	Vibration
	Noise
Micropositioners:	Manipulation devices
Adaptive Optics:	Deformable mirrors
Range Finders:	Pulse-Echo transducers
Displays:	Large area shutter elements

Medical

Apnea Monitors:	Body wrap
	Crib-mattress
Blood Pressure:	Cuff
IV Fluid Monitors:	Flow and level
	Drop counter
Pacemaker:	Handicapped switch
	Gait
	Startle
Ultrasound:	Imaging systems
Instant Thermometer:	Pyroelectric response
Osteogenesis:	Bone and wound healing

Telecommunications

Microphones:	Various models
Speakers:	Handset and Squawk-box
Keypads	
Tone Generators	

Consumer

Musical Instrument	
Pick-ups:	Custom models for
	OEM and after market
Sports Equipment:	Martial arts, foul line, touch pad

Toys-Games:	jogger shoe
Acoustic Speakers:	Various models
	Headset
	Tweeter
	Automotive
Switches:	Musical keyboards

SUMMARY

Discovered less than 20 years ago, a new family of piezo-and-pyroelectric transducers based on highly polar polyvinylidene fluoride film has emerged from the laboratory to become a commercial reality.

Certain properties of piezo film, such as an extremely wide frequency range, a broad dynamic response, and a low acoustic impedance, make it attractive for many applications. What is truly unique is its physical form—a flexible, compliant, clear plastic film that can be readily cut, shaped, and glued to form intricate transducers at relatively low cost.

The applications of piezo film transducers cut across a broad spectra—from rather simple switches to complex robotic tactile sensors. An important consequence of the availability of a unique new form of electroactive material is the opportunity for innovation in sensor design. Indeed, it is the possibilities that make this product exciting. We hope this article will stimulate those involved in sensor design and application to study piezo film in more detail.

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Piezo Film Sensors

Technical Manual

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INTRODUCTION

Transducer materials convert one form of energy into another, and are widely used in sensing applications. The tremendous growth in the use of microprocessors has propelled the demand for sensors in diverse applications. Today, **PIEZOELECTRIC POLYMER SENSORS** are among the fastest growing of the technologies within the \$18 billion worldwide sensor market. Like any new technology, there have been an extraordinary number of applications where "**PIEZO FILM**" has been considered for the sensor solution. In the 20 years since the discovery of piezoelectric polymer, the technology has matured, practical applications have emerged from a long list of possibilities, and the rate of commercialization of the technology is accelerating.

These documents provide an overview of piezoelectric polymer technology and nomenclature, its properties, and sensor design considerations. It also explores a range of sensor applications that have been successfully developed in recent years.

Solving unique sensor problems is a particular strength of our group of applications engineers. We welcome the opportunity to provide assistance to you during your evaluation of piezo film sensors for your design.

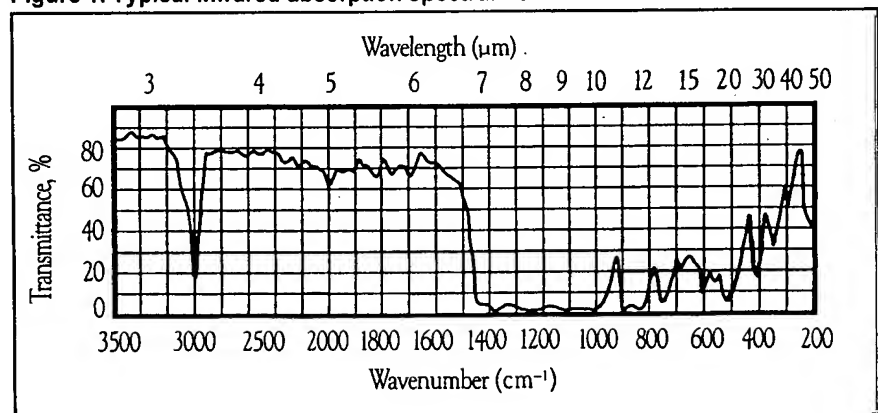
BACKGROUND

Piezoelectricity, Greek for "pressure" electricity, was discovered by the Curie brothers more than 100 years ago. They found that quartz changed its dimensions when subjected to an electrical field, and conversely, generated electrical charge when mechanically deformed. One of the first practical applications of the technology was made in the 1920's by another Frenchman, Langevin, who developed a quartz transmitter and receiver for underwater sound - the first SONAR. Before World War II, researchers discovered that certain ceramic materials could be made piezoelectric when subjected to a high polarizing voltage, a process analogous to magnetizing a ferrous material.

By the 1960's, researchers had discovered a weak piezoelectric effect in whale bone and tendon. This began an intense search for other organic materials that might exhibit piezoelectricity. In 1969, Kawai found very high piezo-activity in the polarized fluoropolymer, polyvinylidene fluoride (PVDF). While other materials, like nylon and PVC exhibit the effect, none are as highly piezoelectric as PVDF and its copolymers.

Like some other ferroelectric materials, PVDF is also pyroelectric, producing electrical charge in response to a change in temperature. PVDF strongly absorbs infrared energy in the 7-20 μ m wavelengths (see Figure 1), covering the same wavelength spectrum as heat from the human body. Accordingly, PVDF makes a useful human motion sensor as well as pyroelectric sensor for more sophisticated applications like vidicon cameras for night vision and laser beam profiling sensors. A dense infrared array has been recently introduced that identifies one's fingerprint pattern using the pyro effect of piezo polymer.

Figure 1. Typical infrared absorption spectrum of PVDF film.



New copolymers of PVDF, developed over the last few years, have expanded the applications of piezoelectric polymer sensors. These copolymers permit use at higher temperatures (135°C) and offer desirable new sensor shapes, like cylinders and hemispheres. Thickness extremes are possible with copolymer that cannot be readily attained with PVDF. These include ultrathin (200 Å) spin-cast coatings that enable new sensor-on-silicon applications, and cylinders with wall thicknesses in excess of 1200µm for sonar. Piezo cable is also produced using copolymer.

PIEZOELECTRIC FILM PROPERTIES

Piezo film is a flexible, lightweight, tough engineering plastic available in a wide variety of thicknesses and large areas. Its properties as a transducer include:

- Wide frequency range—0.001 Hz to 10^9 Hz.
- Vast dynamic range (10^{-8} to 10^6 psi or µ torr to Mbar).
- Low acoustic impedance—close match to water, human tissue and adhesive systems.
- High elastic compliance
- High voltage output—10 times higher than piezo ceramics for the same force input.
- High dielectric strength—withstanding strong fields (75V/µm) where most piezo ceramics depolarize.
- High mechanical strength and impact resistance (10^9 — 10^{10} Pascal modulus).
- High stability—resisting moisture (<0.02% moisture absorption), most chemicals, oxidants, and intense ultraviolet and nuclear radiation.
- Can be fabricated into unusual designs.
- Can be glued with commercial adhesives.

One major advantage of piezo film over piezo ceramic is its low acoustic impedance which is closer to that of water, human tissue and other organic materials. For example, the acoustic impedance ($Z_0 = \rho v$) of piezo film is only 2.6 times that of water, whereas piezo ceramics are typically 11 times greater. A close impedance match permits more efficient transduction of acoustic signals in water and tissue.

Piezo film does have some limitations for certain applications. It makes a relatively weak electromechanical transmitter when compared to ceramics, particularly at resonance and in low frequency applications. The copolymer film has maximum operating/storage temperatures as high as 135°C, while PVDF is not recommended for use or storage above 100 °C. Also, if the electrodes on the film are exposed, the sensor can be sensitive to electromagnetic radiation. Good shielding techniques are available for high EMI/RFI environments.

Table 1 lists typical properties of piezo film. Table 2 provides a comparison of the piezoelectric properties of PVDF polymer and two popular piezoelectric ceramic materials.

Piezo film has low density and excellent sensitivity, and is mechanically tough. The compliance of piezo film is 10 times greater than the compliance of ceramics. When extruded into thin film, piezoelectric polymers can be directly attached to a structure without disturbing its mechanical motion. Piezo film is well suited to strain sensing applications requiring very wide bandwidth and high sensitivity. As an actuator, the polymer's low acoustic impedance permits the efficient transfer of a broadband of energy into air and other gases.

Table 1. Typical properties of piezo film

Symbol	Parameter		PVDF	Copolymer	Units
t	Thickness		9, 28, 52, 110	<1 to 1200	μm (micron, 10^{-6})
d_{31}	Piezo Strain Constant		23	11	$10^{-12} \frac{\text{m/m}}{\text{V/m}} \text{ or } \frac{\text{C/m}^2}{\text{N/m}^2}$
d_{33}			-33	-38	
g_{31}	Piezo Stress constant		216	162	$10^{-3} \frac{\text{V/m}}{\text{N/m}^2} \text{ or } \frac{\text{m/m}}{\text{C/m}^2}$
g_{33}			-330	-542	
k_{31}	Electromechanical Coupling Factor		12%	20%	
k_t			14%	25-29%	
C	Capacitance		380 for 28 μm	68 for 100 μm	pF/cm ² @ 1KHz
Y	Young's Modulus		2-4	3-5	10^9 N/m^2
V_0	Speed of Sound	stretch:	1.5	2.3	10^3 m/s
		thickness:	2.2	2.4	
p	Pyroelectric Coefficient		30	40	$10^{-6} \text{ C/m}^2 \text{ }^\circ\text{K}$
ϵ	Permittivity		106-113	65-75	10^{-12} F/m
ϵ/ϵ_0	Relative Permittivity		12-13	7-8	
ρ_m	Mass Density		1.78	1.82	10^3 kg/m
ρ_e	Volume Resistivity		$>10^{13}$	$>10^{14}$	Ohm meters
R_{\square}	Surface Metallization Resistivity		<3.0	<3.0	Ohms/square for NiAl
R_{\square}			0.1	0.1	Ohms/square for Ag Ink
$\tan \delta_e$	Loss Tangent		0.02	0.015	@ 1KHz
	Yield Strength		45-55	20-30	10^6 N/m^2 (stretch axis)
	Temperature Range		-40 to 80...100	-40 to 115...145	$^\circ\text{C}$
	Water Absorption		<0.02	<0.02	% H ₂ O
	Maximum Operating Voltage		750 (30)	750 (30)	V/mil(V/ μm), DC, @ 25 $^\circ\text{C}$
	Breakdown Voltage		2000 (80)	2000 (80)	V/mil(V/ μm), DC, @ 25 $^\circ\text{C}$

Table 2. Comparison of piezoelectric materials

Property	Units	PVDF Film	PZT	BaTiO ₃
Density	10 ³ kg/m ³	1.78	7.5	5.7
Relative Permittivity	ϵ/ϵ_0	12	1,200	1,700
d_{31} Constant	(10 ⁻¹²)C/N	23	110	78
g_{31} Constant	(10 ⁻³)Vm/N	216	10	5
k_{31} Constant	% at 1 KHz	12	30	21
Acoustic Impedance	(10 ⁶)kg/m ² -sec.	2.7	30	30

OPERATING PROPERTIES FOR A TYPICAL PIEZO FILM ELEMENT

The DT1 element is a standard piezo film configuration consisting of a 12x30 mm active area printed with silver ink electrodes on both surfaces of a 15x40 mm die-cut piezo polymer substrate.

1. Electro-Mechanical Conversion

(1 direction) 23×10^{-12} m/V, 700×10^{-6} N/V
(3 direction) -33×10^{-12} m/V

2. Mechano-Electrical Conversion

(1 direction) 12×10^{-3} V per microstrain, 400×10^{-3} V/ μ m, 14.4V/N
(3 direction) 13×10^{-3} V/N

3. Pyro-Electrical Conversion

8V/°K (@ 25°C)

4. Capacitance

1.36×10^{-9} F; Dissipation Factor of 0.018 @ 10 KHz; Impedance of 12 K Ω @ 10 KHz

5. Maximum Operating Voltage

DC: 280 V (yields 7 μ m displacement in 1 direction)
AC: 840 V (yields 21 μ m displacement in 1 direction)

6. Maximum Applied Force (at break, 1 direction)

6-9 kgF (yields voltage output of 830 to 1275 V)

Electrical to Mechanical Conversion

Large displacements of forces are not generally available from piezo film. This becomes apparent when designing loudspeaker elements for instance, as low frequency performance (below 500Hz) tends to be limited. Even a large sheet of film is unable to create high amplitude pressure pulses as low audio frequencies. This does not apply, however, to low to high frequency ultrasonic frequencies, as seen in current designs for ultrasound air ranging transducers (40-50 KHz) and in medical ultrasonic imaging applications. In enclosed air cavities (headset speakers, hearing aids), the low frequency response of piezo film is excellent. For air ranging ultrasound, the piezo film element height controls vertical beam angle and the curvature and width of the transducer controls horizontal beam pattern. Piezo film air ranging transducers can provide up to 360° field of view, ranging object from a few centimeters to several meters with high resolution.

Bimorph configurations (like a bimetal strip) allow the small differential displacement of two reverse-connected elements to be translated into substantial flexural motion. Small fans or optical deflectors can thus be created. Such devices consume very little real power (being capacitive in nature). Large devices may be difficult to drive due to high capacitance, especially when transformers are used to step up the drive voltage. Good amplifier design is important. Nevertheless, conventional fan and blower technologies generate higher flow rates and back pressures than piezo bimorphs.

Although the forces involved are small, the film can be used to excite other mechanical structures over a very wide frequency range. If a second element of film is used to receive the induced vibration, the system can possess a very high dynamic range, even though the overall "insertion loss" due to the film is about -66 dB typically for a structure at resonance. If sufficient gain is applied between these elements, the structure will self-oscillate at its natural frequency. For these resonant mechanical systems, high voltage drive is not required. The amplifier circuit may function adequately from a normal dual rail op-amp supply, or even from a single 9 volt battery. For analysis purposes, even lower applied voltages, e.g., the noise source of a spectrum analyzer at 70 mVrms, are sufficient to insert the mechanical energy into a structure when piezo film is also used to monitor the result.

Mechanical to Electrical Conversion

The sensitivity of piezo film as a receiver of mechanical work input is awesome. In its simplest mode the film behaves like a dynamic strain gage except that it requires no external power source and generates signals greater than those from conventional foil strain gages *after* amplification. Frequency response is thus free from any limitations imposed by the need for high gains and will extend up to the wavelength limit of the given transducer.

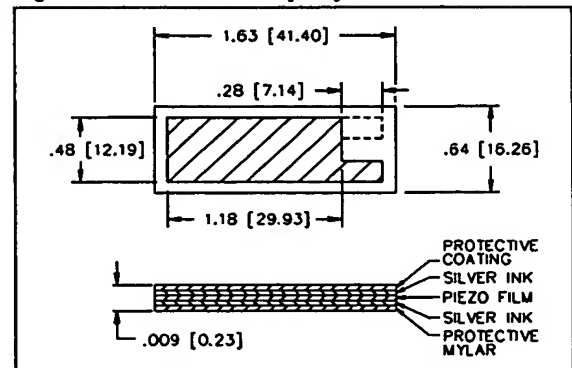
The extreme sensitivity is largely due to the format of the piezo film material. The low thickness of the film makes, in turn, a very small cross-sectional area and thus relatively small longitudinal forces create very large stresses within the material. It is easy to exploit this aspect to enhance the sensitivity parallel to the machine axis. If a laminated element of film (for example an LDT1-028K) is placed between two layers of compliant material then any compressive forces are converted into much larger longitudinal extensive forces. In fact, this effect tends to predominate in most circumstances since most substances are compliant to some extent and the ratio of effective sensitivity in the 1 (length) vs 3 (thickness) directions is typically 1000:1.

Piezo film transducers may often cover a much larger area than normal strain gages so any direct comparisons should be performed in a *uniform* strain field for meaningful results. Obviously "point"-type transducers could be used where required although the capacitance of a very small area will require consideration. The low frequency limit of operation will be defined by the greatest resistive load achievable, or by the largest capacitance load that still allows the signal to be easily detected. Operation down to fractions of Hz can be achieved using either conventional charge amplifiers or, since signal levels are relatively high, simple high impedance FET buffer circuits.

Pyro to Electrical Conversion

Piezo film absorbs strongly in the region of 7 to 20 μm which corresponds to well beyond both operating temperature limits of the film. It thus makes a sensitive pyroelectric detectors for, say, human body radiation. Since the pyro sensitivity is strong, care must be taken when designing low (<0.01 to 1Hz) frequency mechanical sensors to avoid ambient temperature changes swamping

Figure 3. DT1 Element in [mm]



the output with pyro-generated signal. If a very long time constant is in use, then the film will generate a voltage corresponding to the change in temperature since switch-on. Since the output will be several volts per degree C, substantial offsets may be noticed.

In general, however, most piezo applications will have a cut-off frequency of several Hertz or more. Connecting a device of 1nF capacitance to an oscilloscope input, even at 10 MΩ impedance, will produce a roll off below 16 Hz. Only a more rapid change in the film temperature will generate a detectable signal.

Common-mode rejection can be used to isolate either very low frequency mechanical strain from simultaneous pyro-effects or vice-versa. These straight-forward techniques are quite familiar to MSI applications engineers who are available for design assistance.

Electrical Design Considerations

A useful model for piezo film which applies for most cases except ultrasonic applications is a strain-dependent voltage source in series with a capacitance. Thus any resistive load will form a divider network with a simple RC high-pass filter characteristic. The cut-off frequency is given by

$f_c = \frac{1}{2\pi RC}$ and the time constant $\tau = RC$. Operation below the cut-off frequency will give an output signal proportional to the rate of change of the input parameter (differentiator). Application of a constant stress will generate an initial level followed by an exponential decay of rate $\exp(RC)^{-1}$.

A capacitive load will extend the time constant but reduce the magnitude of the response. Energy is always lost when transferring charge from one capacitor to another. Large capacitive loads are useful for attenuating the very large signals arising from powerful impacts—often hundreds of volts.

When driving the film at high voltage and high frequency, the dissipation factor of the film may result in substantial energy loss in the form of heat. Also, the surface resistivity of the electrodes may become significant, especially with vacuum metallized film. Very high localized currents may be encountered. Operation within the field limits given in the Technical Manual is strongly recommended since any arcing will normally destroy the device.

Silver ink, screenprinted onto both film surfaces, has been developed to withstand high voltage and high localized currents. The silver ink metallization has been successfully used in tweeters and active vibration damping applications. The DT1 sample is electroded with the silver ink. The unmetallized border mitigates potential for arcing across the film's thickness. The offset lead attach tabs also preclude high voltage breakdown, as the conductor at each lead attach site is on one side only.

Mechanical Design Considerations

The output energy is proportional to the volume of film stressed. Film thickness may be chosen to optimize the electrical signal or in view of mechanical strength considerations. Thicker films generate higher voltages but form smaller capacitors, so a laminate of thinner film with a compatible, passive material such as polyester (i.e. the LDT1-028K) may be preferable to a single thicker film. Any area of film that is not undergoing stress will act as a capacitive load on the "active" area and should be minimized if required.

Most metallizations are subject to corrosion, especially when handled. Thin conformal coatings or laminates are frequently applied to maintain surface quality. Acrylics adhesives, synthetic rubber resins, epoxies and cyano-acrylates are all frequently employed in lamination and assembly.

Some designs may use external metallic or conductive substrates as the electrodes, in which case unmetallized film may be used to good advantage. The external metal surface can be in direct

contact with the unmetallized film to collect the charge, or, capacitive coupling through thin adhesive tapes or epoxy layers can be employed for ac applications. Patterning of the electrodes is especially useful for defining specific active areas on a continuous sheet and also to allow die-cutting of elements with a clear border around the cut area. Displacement (offset) of upper and lower electrode tabs at the connection point is good practice to prevent unpredictable piezo behavior in this area caused by the influence of the wire terminations. This also allows low cost penetrative lead-attach methods to be used (crimps or eyelets).

Joint Electrical and Mechanical Design Considerations

The capacitive nature of piezo film devices implies that they are susceptible to Electro Magnetic Interference (EMI). This becomes increasingly more important as the output signal level drops. EMI can be ignored where the output is high or when the film is being driven in a non-critical environment. A.C. mains interference may become a problem with unshielded devices. Another potential problem exists when one electrode element is being driven and another is receiving the vibration signal. Care must be taken to avoid "crosstalk".

Use of ready-made shielded elements (SDT1-028K) supplied with coaxial cable eliminates these problems, but simple measures may be taken with any device to avoid interference.

Unwanted frequencies may be filtered out electronically. If the sensor is to be mounted on a conductive substrate, then this may form one half of a grounded envelope, with the outer electrode forming the other half. Lightweight shielded cable is readily available and is an alternative to twisted pair wires. Attention should be paid to the point of connection itself as this is also an area of EMI vulnerability.

Durable lead attachment techniques have been fully developed by MSI, and most products are supplied with leads preattached. As indicated, some form of coaxial cable is often employed and must be interfaced to a very thin flexible material. Reinforcement at the lead attach site may be required, which can introduce some acoustic effects into the transducer if the interconnection site is free to vibrate.

Thin copper foil backed with a conductive adhesive can provide excellent but non-permanent connections to the film. An area of 1 cm² will give a contact resistance of a few mΩ. Crimp-through connectors as used for flexible circuits are routinely used with offset electrode patterns, but thin films require some physical reinforcement for good results. Polyester reinforcement at the lead attach site is a common method to ruggedize the interconnection. The stiffener may lie between the crimp and the electrode with only minor degradation of contact resistance. Typical values are 150-500 mΩ. Miniature rivets, eyelets and even nuts and bolts, with washers, all combine great strength with good contact resistance at typically less than 100 mΩ. These techniques may be used to connect to cables using solder tags, or direct onto printed circuit boards.

Clamping methods, either direct to the conductive traces on the PCB or using conductive rubber, ZEBRA® connectors, lugs and washers have all been used with success. Direct connection using silver-loaded (conductive) epoxy also works well, but requires curing time, often at elevated temperature, for best results.

As indicated earlier, other materials may form the electrodes themselves, such as PCB traces or conductive rubber. Capacitive coupling through thin adhesive layers is practical under some a.c. circumstances, allowing some unusual transducer designs with apparently no lead attachment at all!

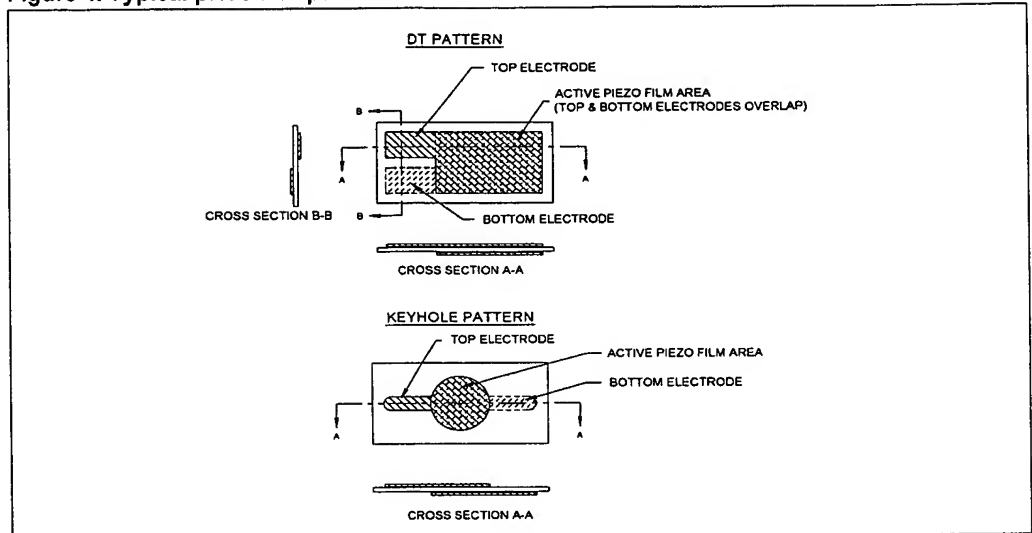
ZEBRA is a registered trademark of Fujipoly.

LEAD ATTACHMENT TECHNIQUES FOR PIEZO FILM SENSORS

Introduction

How to make reliable interconnection to piezo film is one of the most frequently asked customer questions. With this in mind, MSI has paid great attention to the development of techniques to simplify interconnection to piezo film elements. Today, most of the sensor elements supplied to customers from our Division have leads already attached. The aim of this article is to examine and discuss available interconnection options.

Figure 4. Typical piezo film patterns



Some of the most convenient interconnection techniques require that MSI apply patterned electrodes on one or both surfaces of the piezo film—this can always be done to customers' requirements during manufacture— alternatively, a simple method achieving the same goal is presented at the end of the text. In general, patterned electrodes are achieved during piezo film manufacturing by screen printing conductive inks, metal masking during sputtered electrode deposition, or chemically etching patterns by photolithographic techniques.

The Targets

Considered here are the design objectives desired for the lead-attach method. Not all objectives can be achieved with any one technique. Designers should identify the most important objectives and select among the interconnection options accordingly.

- ! High conductivity/low resistance — surprisingly, high conductivity interconnection is not a particularly important parameter for most piezoelectric applications. Piezo transducers are frequently used in high-impedance circuits where inclusion of a few ohms does not usually affect performance. More important, however, is consistence—the resistance should not fluctuate during use since this will introduce a source of electrical noise.
- ! Low mass — this is especially important when the piezo film is not to be clamped to a mechanical support structure. The acoustic effect created by the mechanical vibration of the mass of the interconnection on an otherwise flexible structure can be dramatic.
- ! Low profile — many piezo film applications arise by virtue of the low thicknesses of piezo film. Interrupting this with bulk terminations is often prohibited. Contact vibration sensors can show distinct resonances if film is not bonded flush to the contact surface to include the interconnection.
- ! Flexibility — here again is a property that must often match that of the film itself. Some degree of flexibility is a distinct advantage in many applications.
- ! Low area — useful piezo devices can be quite literally be employed as "point" receivers. Small piezo-active areas (where the top and bottom conductors fully overlap) can be configured with

displaced or off-set lead-attach tabs. The top and bottom tabs are off-set with respect to each other (when viewed through the film thickness). This allows a precisely defined active area (overlapped electrodes) with non-piezo conductors (off-set tabs) leading to remote bonding sites, a technique most frequently employed for "small" devices.

- ! Mechanical Strength — very often the greatest strain experienced by a polymer transducer is around the connection, whether by accident (tripping over the cable) or by design. In general, those methods which involve the interconnection penetrating through the film at the off-set tab locations with crimps, eyelets or rivets yield the best ultimate strain resistance. Often the lead attach area is reinforced with polyester to improve the strength of the penetrative interconnection.
- ! Long-term Stability — including all the usual environmental parameters. Most interconnections have unlimited life (crimps, eyelets, conductive rubber connectors). Others have a more limited shelf life (conductive tapes)
- ! Speed and Ease of application — of particular importance when high volume production is planned. Many interconnection techniques are supported by semi-automatic equipment for volume production (crimps, eyelets) while others are labor intensive (conductive adhesives).
- ! Electrical strength — an issue associated mainly with electrically driven (high voltage) elements such as loudspeakers and actuators.

The Design Considerations

Two major issues control the selection of lead-attach methods:

- ! Is anchorage of the film allowed at the site of lead-attach? This can be a major advantage, for example, direct connection or capacitive coupling to the conductive traces of a printed-circuit board.
- ! Is special patterning of the film available, which would allow penetrative techniques? (with MSI Sensors custom patterning service, the answer is almost always "yes.") Simple experimental methods allow the same result.

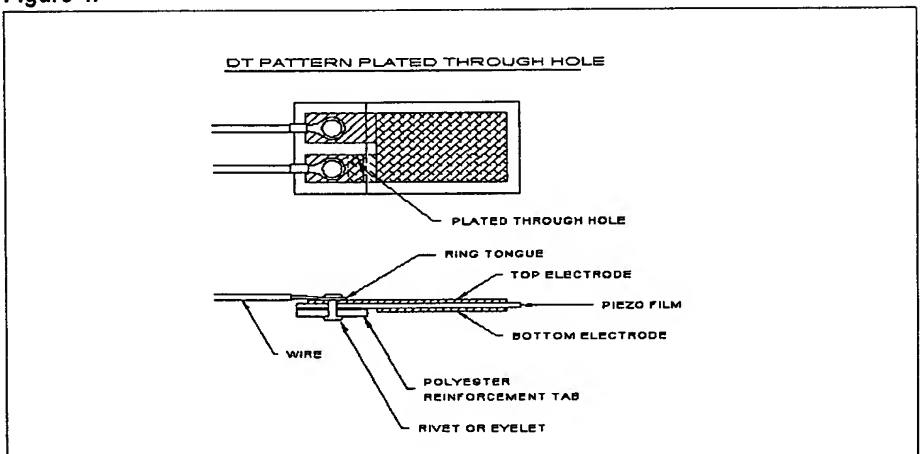
This concludes the "questions" section—now, hopefully, are the "answers."

The Methods

Penetrative - Here the techniques involve piercing the film (and possibly additional reinforcing laminates to give sufficient thickness and strength), and thus the film should be patterned with a displaced or off-set lead-out arrangement to prevent shorting of upper and lower electrodes by the inserted connector.

- ! Rivets or eyelets can be affixed to the off-set conductive traces on the piezo film. Included between the eyelet or rivet can be a ring tongue lug terminal with wire attached. The eyelet or rivet mechanically presses the conductive ring against the off-set patterned electrode to make reliable interconnection.

Figure 4.



! To affix the piezo film directly to a PCB, small "POP" or "blind" rivets or eyelets can be used in conjunction with patterned film electrodes and the conductive tracks on the PCB to allow a single operation to form the interconnection. During screen printing of conductive ink electrodes, a small "plated through hole" can be formed in one of the off-set tabs, thereby bringing both conductors to the same side of the piezo film. This greatly facilitates riveting the film electrode tabs to the corresponding PCB traces. If the "plated through hole" technique is not used, then the top film electrode can be electrically connected by the rivet to a conductive trace on the underside of the PCB. The bottom film electrode is electrically connected to a corresponding trace on the top of the PCB and held in intimate contact by the pressure exerted by the rivet.

! Nuts and bolts - Wires terminated with washers, ring-tongue lugs, solder-tags, etc. can easily be incorporated with small nuts and bolts.

! Crimp Connectors — generally, crimps designed for flexible circuit technology work well with piezo film elements. Crimps can have solder tabs for affixing wires, or the crimp ends can be inserted into corresponding holes in a PCB and soldered to the underside of the PCB (maximum of a few second soldering time so as not to overheat the film). Like the eyelets mentioned above, crimps are normally designed to work with a specified thickness of "substrate," so film may require "padding" on one side (i.e., polyester reinforcement) to accommodate the crimp connectors. Additionally, a complete multi-way connector may be crimped to a more complex device, giving straight plug-in compatibility with other connectors.

Figure 5.

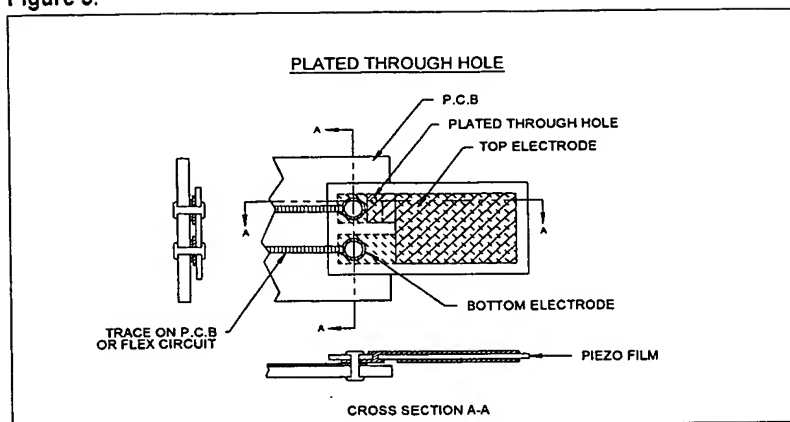


Figure 6.

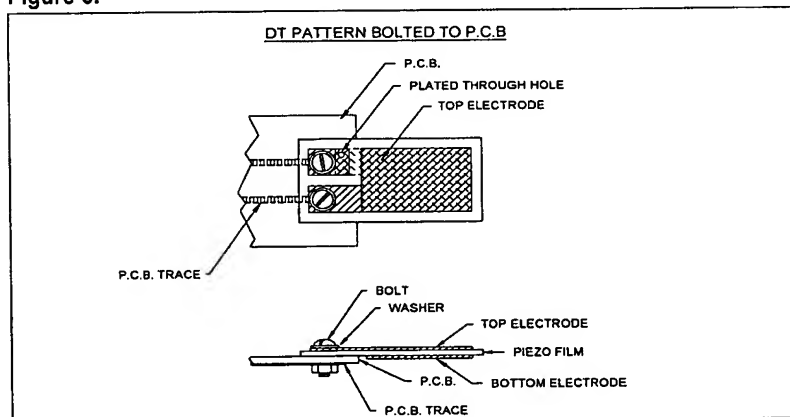
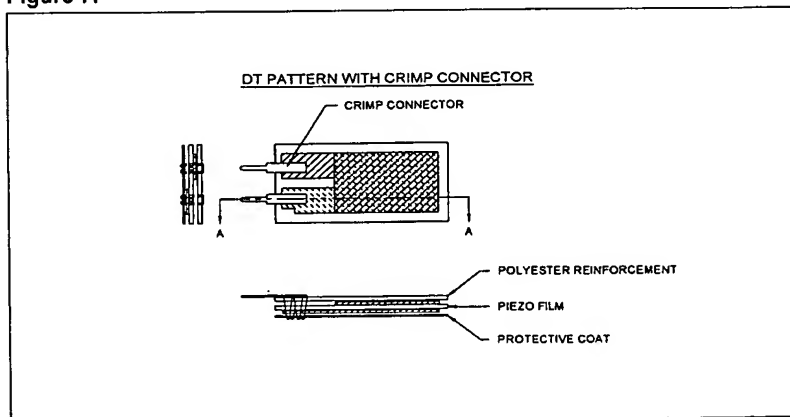


Figure 7.



Non-penetrative (and temporary) - Conductive-adhesive coated Copper Foil Tape (e.g., 3M #1181)—available in widths from 3mm up to 25mm. Best results are obtained by...

! Using a "reasonable" area of tape (perhaps about 1cm or more). Small pieces do tend to lift off easily.

! Soldering wires to the tape FIRST, then removing the liner and adhering with gentle pressure to film. If small areas are to be used, solder before cutting the contact pad down to size, thus leaving the excess area to act as a heat sink. Soldering does appear to degrade the adhesive properties in the vicinity of the joint. NOTE: 3M does not recommend relying on the conductive adhesive in this way and suggest an embossed

version of the same tape. The tape is really designed for large area contacts to metal, but results have shown this method to be an effective, if not guaranteed, technique. An aluminum version of this product is available (Part No. 1170). Beware of similar tapes that do not have conductive adhesives (although these can be used for shielding, etc.)

! Conductive Transfer Tape—e.g., 3M #9702 (Preliminary product). An acrylic adhesive layer loaded with conductive particles giving excellent "Z-axis" conductivity (i.e., through the thickness of the tape) with very high resistivity in the X and Y axes. Thus single or multiple-way connections may be made with a single strip. This material is relatively new. Initial results seem very promising. Obviously this can be used to make direct connection with PC board or strip, or to sections of foil with soldered leads.

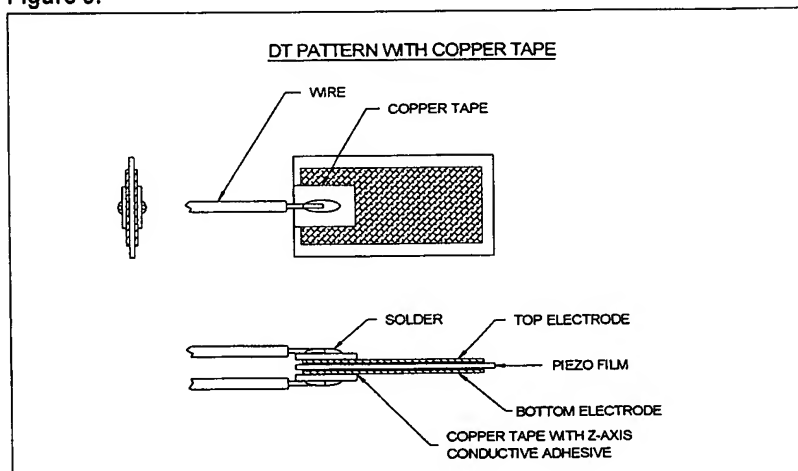
! Negative aspects are a) high cost, and b) like all transfer adhesives, there is a tendency for the material to adhere to its own liners around the edge so that "stringing" occurs on liner removal. NOTE: Since time of writing, this product has been superseded by an improved version (#9703) with an easy-release liner. This may not yet be generally available.

! Conductive Epoxy. This is usually available in two-part form (adhesive and hardener). Precise metering and mixing of the small quantities usually required is rather difficult and messy. One-part, pre-mixed material is available as a product which is stored at very low temperature and should be used and cured at room temperature. Curing of any epoxy mix can usually be accelerated by use of higher temperature, but since the piezo film has a modest high-temp capability, curing is often a long term process (many hours, a day). Some mechanical clamping is usually required on the parts to be bonded. Final reinforcement with "ordinary" epoxy can be reassuring. Negative aspects: difficulty of use, cure time, higher cost, short "shelf life."

! Low melting-point Alloys—some alloys (e.g., Indium/Tin/Bismuth) which are known as "fusible alloys" rather than "solders," melt at temperatures which allow them to be used on piezo film with suitable metallization (e.g., gold, copper, silver or silver ink). Rather aggressive fluxes are often required, and the joint may be brittle. Mechanical strength is limited by the adhesion of the metallization onto the film surface, so once again, reinforcement with epoxy may help. For joints that must be very small and do not need undue mechanical strength this may prove a valuable technique. Negative aspects: only certain metallizations are appropriate, sample quantities hard to come by. Mechanical strength limited [Indium Corp.]

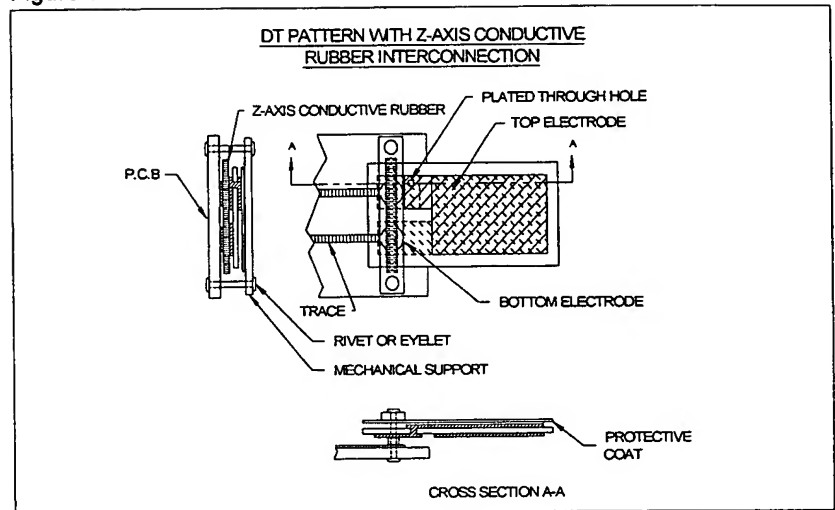
! Zebra® Connectors — Conductive rubber spliced with insulating rubber as used to form contacts to LCD displays. High density multiple-way contacts may be made. External clamping of contacts is required.

Figure 9.



- ! Mechanical clamping—simply sandwiching the film between two conductive surfaces (possibly using a thin layer of conductive-loaded rubber) can provide excellent results. Two rings can provide useful support for diaphragms, speakers, etc.
- ! Capacitive Coupling - In certain applications, no metal electrode is required on the piezo film itself. Thin, non-conductive adhesives can affix the unmetallized film to a conductive surface. The conductive surface in effect provides the film's electrodes in ac applications. A PCB, having conductive pads on one surface corresponding to the desired active sensor area, is an embodiment of this concept. The opposite piezo film surface can be metallized with a ground electrode. The film can be sandwiched between two conductive surfaces with or without adhesive to form electrodes.

Figure 10.



User Etching of Piezo Film Electrodes

Patterned electrodes are available from MSI in either silver screen printed ink or as sputtered electrodes. In some instances, customers purchase fully metallized sheets for experimentation, and want to produce their own patterns. This is very difficult with screen printed inks as they cannot be easily etched or mechanically braided. For sputtered electrodes, standard photolithographic techniques work quite well.

In order to pattern piezo film in such a way as to allow penetration of film without shorting top and bottom electrodes, a very simple technique may be employed which works on any vacuum deposited electrodes (NOTE: not recommended for Ag Ink.)

One terminal of a power source (bench p.s.u. or 9 volt battery) is connected via a conductor pad or block by mechanical pressure to the piece of film in question. The other terminal is brought to a conductive point (needle, wire-end, blunt scalpel, etc.) and the area required to be isolated simply drawn around. Sufficient current normally passes to cause arcing at the point contact and the metallization is vaporized. Concentric "guard rings" may be drawn for extra confidence.

For more complex patterning of thin sputtered metallization, it is possible to coat the piezo film with photoresist aerosol (both sides if necessary). The cured spray can then be exposed through a mask using UV light, as with conventional PCB techniques, and then dipped in an etchant. Complete etching of the very thin metal layer occurs in seconds.

Copper/Nickel metallizations etch very well with standard PCB etchant (ferric chloride). Other metals require special etchants for good results (Aquaregia for gold). Remember that the metallization layer may only be a few hundred atoms thick (300-700 Å), and therefore fine traces are very vulnerable to scratching or cracking.

High Voltage Techniques

The use of piezo film as a vibration exciter requires separate consideration. Since the impedance of a capacitive transducer decreases with frequency and approaches infinity for low frequencies, very high voltages (a few hundred volts typically) may be required to drive, for example, full audio-range loudspeakers. Frequently, transformers are used to step up moderate voltages to supply the required drive signal. Under these circumstances, extreme stresses may be placed upon the connections. Consider first applying a voltage step of 30V to a capacitor of 100nF with an overall circuit resistance of 2 ohms. The initial current pulse peaks at 15 amps (assuming the supply is capable of supplying this). Such a current "spike" may well show up defects in connectors.

Consider next a transformer which steps 12V signals up to 240V. A DC current in the primary of 200 μ A (corresponding to an applied voltage of 0.5 volts), when broken, may cause a voltage surge of 830 volts across the secondary circuit, well in the excess of the expected X 20 magnification factor. Even with heavy capacitive loading, high voltages may be seen. Worse still, if the secondary circuit is broken, current pulses exceeding 60A with durations of only tens of nanoseconds may arise. Such phenomena should not trouble well-formed connections. But if a lead-attach method has been used which has any trapped air, the effect of the reduced dielectric constant may be to promote breakdown. Such events may be catastrophic, as the familiar crackling sound and lively blue sparks will testify.

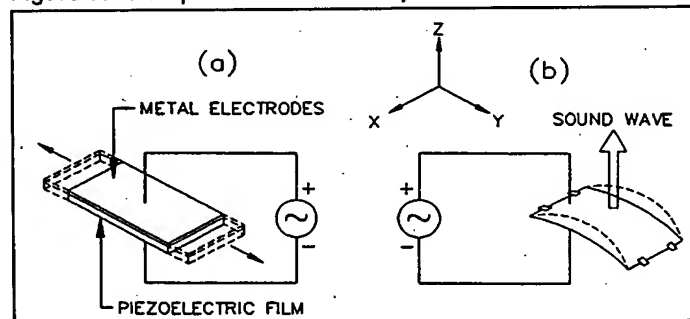
Solutions are:

1. Silver ink electrodes are a must - the thin sputtered electrodes cannot withstand the high voltages
2. Large area contacts to reduce stress. We paint silver ink around eyelets/rivets to provide extra conduction paths to the film electrode.
3. (Possibly) a semi-resistive contact pad to reduce current surges—equivalent to including a series resistance in the circuit. Practical values up to about 1 k will produce only a fractional loss in output and will reduce the magnitude of current spikes.

FREQUENCY RESPONSE

Unlike piezo ceramic transducers, piezo film transducers offer wide dynamic range and are also broadband. These wide band characteristics (near dc to 2GHz) and low Q are partly attributable to the polymers' softness. As audio transmitters, a curved piezo film element, clamped at each end, vibrates in the length (d_{31}) mode, as shown in Figure 10. Piezo film is a very high fidelity tweeter, also used in novelty speakers for toys, inflatables and apparel. The d_{31} configuration (Figure 10) is also used for air ultrasound ranging applications up to frequencies of about 50 KHz.

Figure 10. Clamped film in d_{31} mode produces sound



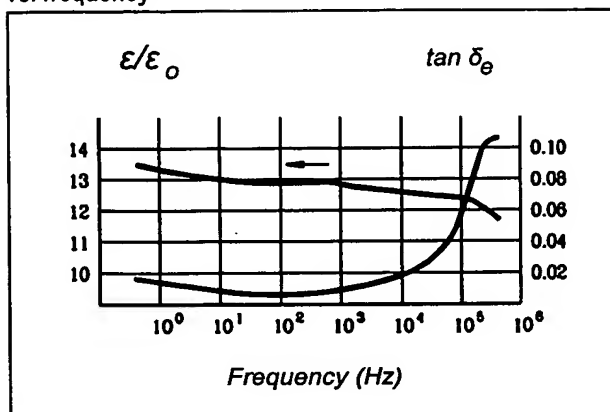
When used as a high ultrasonic transmitter (generally >500KHz), piezo film is normally operated in the thickness (d_{33}) mode. Maximum transmission occurs at thickness resonance. The basic half-wavelength resonance of 28 μ m piezo film is about 40 MHz:

$$f_r = \frac{v}{2t} = \frac{2.2 \times 10^3 \text{ m/sec}}{2 \times 28 \times 10^{-6} \text{ m}}$$

Resonance values thus depend on film thickness. They range from low MHz for thick films ($1,000\mu m$) to $>100\text{MHz}$ for very thin films.

Figure 11 shows the effect that frequency has on permittivity and dissipation factor at room temperature. As a result of its very low permittivity ϵ (1 percent that of piezo ceramics), the film exhibits g -constants (voltage output coefficients) that are significantly greater than piezo ceramics ($g = d/\epsilon$).

Figure 11. Dielectric permittivity and dissipation factor vs. frequency



PIEZO FILM AT LOW FREQUENCIES

Introduction

The behavior of a piezo film component at low frequencies is fairly straightforward to describe in electrical terms, yet is quite frequently misunderstood. Since any practical application of the technology will most likely involve some consideration of this topic, it is the intent of this article to examine the subject at some length. The treatment is made as non-mathematical as possible, with verbal descriptions and real-world examples being used to illustrate the concepts. Some familiarity with the use of FFT techniques to transform between time-domain and frequency-domain descriptions is assumed, but not essential.

Connecting Up

In most instances, the first evaluation of piezo film begins with connecting a piezo component to an oscilloscope via a probe ("scope probe"). Under normal electronics circumstances, a scope probe can be considered to be an "infinite impedance" - so high, that its effect on the circuit under test can be neglected. **Not so with piezo film** - in many cases, a scope probe can act almost like a short-circuit. Typical probes, when plugged in to an oscilloscope, have an effective *resistance* of $1\text{M}\Omega$ (one million ohms). Others may be fixed at $10\text{M}\Omega$, while many are conveniently switchable between "x1" ($1\text{M}\Omega$) and "x10" ($10\text{M}\Omega$). Note that the physical element comprising the $1\text{M}\Omega$ resistance is usually built into the oscilloscope input stage, rather than being a discrete component within the probe itself. A "x1" probe is thus basically a length of shielded cable with suitable contacts attached to each end.

Source Capacitance

To analyze what will happen when the probe is connected, we now need to consider the properties of the piezo film element. Perhaps the most important characteristic (after the piezoelectric property, of course) is the material's *capacitance*. Capacitance is a measure of any component's ability to store electrical charge, and is always present when two conductive plates are brought close together. In our case, the conductive plates are the conductive electrodes printed or metallized onto each surface of the film. The capacitance of the device is strongly affected by the properties of the insulator serving to space the plates apart, and the measure of the insulator's capacity to store charge is given by its *dielectric constant* or *permittivity*.

PVDF has a high dielectric constant compared with most polymers, with its value being about 12 (relative to the permittivity of free space).

Obviously, the capacitance of an element will increase as its plate area increases, so a large sheet of film will have a larger capacitance than a small element. Capacitance also increases as the film thickness *decreases*, so for the same surface geometry, a thin film will have a higher capacitance than a thick film.

These factors are formally related in the equation:

$$C = \epsilon \frac{A}{t}$$

where C is the capacitance of the film,
 ϵ is the permittivity (which can also be expressed in the form

$\epsilon = \epsilon_r \epsilon_0$ where ϵ_r is the relative permittivity (about 12 for PVDF), and ϵ_0 is the permittivity of free space (a constant, 8.854×10^{-12} F/m)

A is the active (overlap) area of the film's electrodes
 and t is the film thickness

The units of capacitance are Farads (F), but usually much smaller sub-multiples are encountered: microfarads (μF or 10^{-6} F), nanofarads (nF or 10^{-9} F) and picofarads (pF or 10^{-12} F).

Table 3. Capacitance values of common piezo film components

Description	Part No.	Capacitance
LDT0-028K/L	0-1002794-1	500 pF
DT1-028K/L	1-1002908-0	1.3 nF
DT1-052K/L	2-1002908-0	650 pF
DT2-028K/L	1-1003744-0	2.6 nF
DT4-028K/L	1-1002150-0	9 nF
8" x 11" 28 μm	1-1003702-4	30 nF
HYD-CYL-100	0-1001911-1	43 pF

The capacitance of any piezo film element can be calculated using the formula, or measured directly using a hand-held capacitance meter, or bench-top instrument such as an "LCR bridge".

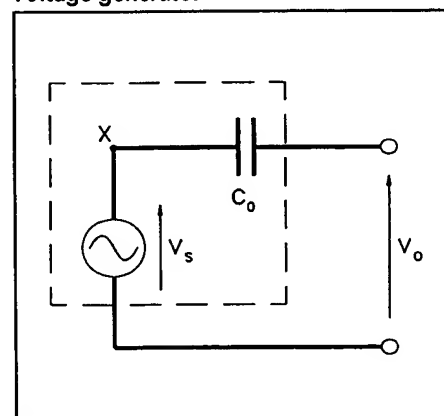
Capacitance values should be quoted at a given measurement frequency - where this is not given, a frequency of 1 KHz is often assumed. Capacitance values of piezo film components usually decrease as the measurement frequency increases.

Equivalent Circuit of Piezo Film

We are now ready to draw out an electrical equivalent of the piezo film element. There are two equally valid "models" - one is a *voltage* source in series with a capacitance, the other a *charge* generator in parallel with a capacitance - but the latter is uncommon in electrical circuit analysis and we will concentrate on the voltage source (see Figure 12).

The dashed line represents the "contents" of the piezo film component. The voltage source V_s is the piezoelectric generator itself, and this source is directly proportional to the applied stimulus (pressure, strain, etc). It is not the purpose of

Figure 12. Piezo film element as a simple voltage generator



this article to elaborate further on the calculations involved, but it is important to realize that this voltage will absolutely follow the applied stimulus - it is a "perfect" source.

Note, however, that the node marked "X" can never be accessed! The film's capacitance C_0 will always be present and connected when we monitor the "output" of the film at the electrodes.

Adding in a resistive load

Now we can add in the effect of connecting up to the oscilloscope. The oscilloscope and its probe are modeled simply as a pure resistance, although in reality there will be a very small capacitance associated with the probe and the cable (usually in the region of 30 to 50 pF). This can be neglected if the film capacitance is significantly higher in value.

The voltage measured across the load resistor R_L will **not** necessarily be the same voltage developed by the "perfect" source (V_s).

To see why, it is helpful to redraw this circuit in another way.

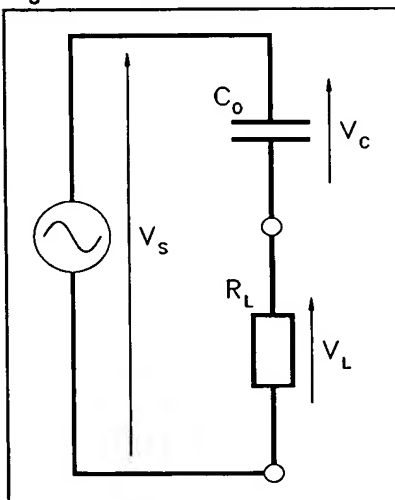
Potential Divider

With the circuit shown in Figure 13 redrawn as in Figure 14, it is easier to see why the full source voltage does not always appear across the resistive load.

A *potential divider* is formed by the *series* connection of the capacitance and the resistance. Since the capacitance has an impedance which varies with frequency, the share of the full source voltage which appears across R_L also varies with frequency.

The proportion (V_L) of V_s which appears across R_L is given by:

Figure 14. Potential divider



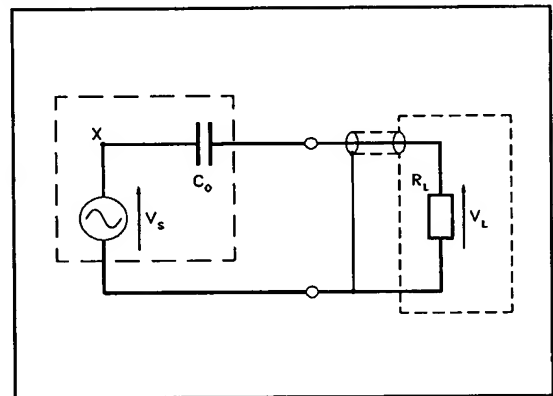
where

$$\frac{V_L}{V_s} = \frac{-jX_C}{R_L + Z_C} = -\frac{j}{2\pi fC}$$

(j denoting $\sqrt{-1}$, and X_C being the reactance of the capacitive element. For simplicity, we ignore any resistive component of the film's impedance).

The above equations may be used in simple ways to calculate the voltage level expected to be observed in simple cases where the frequency of excitation is constant, and so a value of f can simply be substituted. In many real-world cases, however, there may be a distribution of signal energy over a band of frequencies. Then it becomes useful to consider the "frequency response" of the network.

Figure 13. Adding the oscilloscope as resistive load



Frequency Response

This is illustrated in the following example graphs. First, a lin/lin plot is shown (Figure 15, linear y-scale or amplitude, plotted against linear x-scale or frequency) with the corresponding phase plot (Figure 16) also shown in lin/lin form. Following these is a log/log plot (Figure 17), which will be dealt with in a little greater detail.

Note that the phase curve indicates that at very low frequencies, the observed voltage will show significant phase deviation from the source (limiting at -90° or $-\pi/2$ radians at "dc" or zero Hz). The significance of this effect is great if the piezo film element is to be used as part of a control loop.

Figure 15. Magnitude response of R-C filter

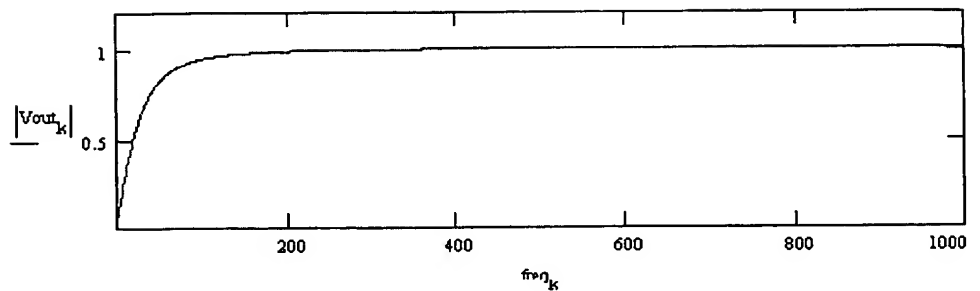


Figure 16. Phase response of R-C filter

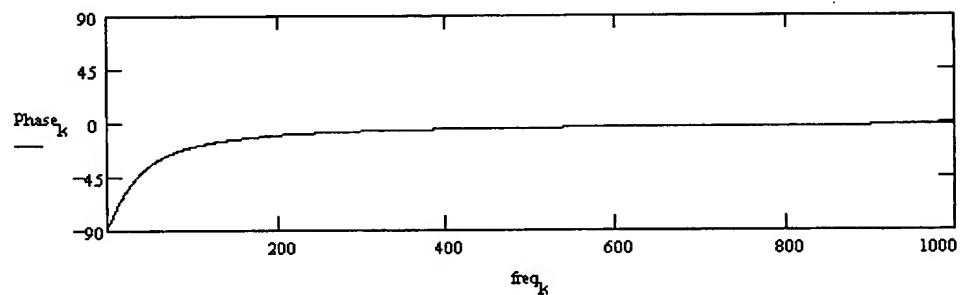
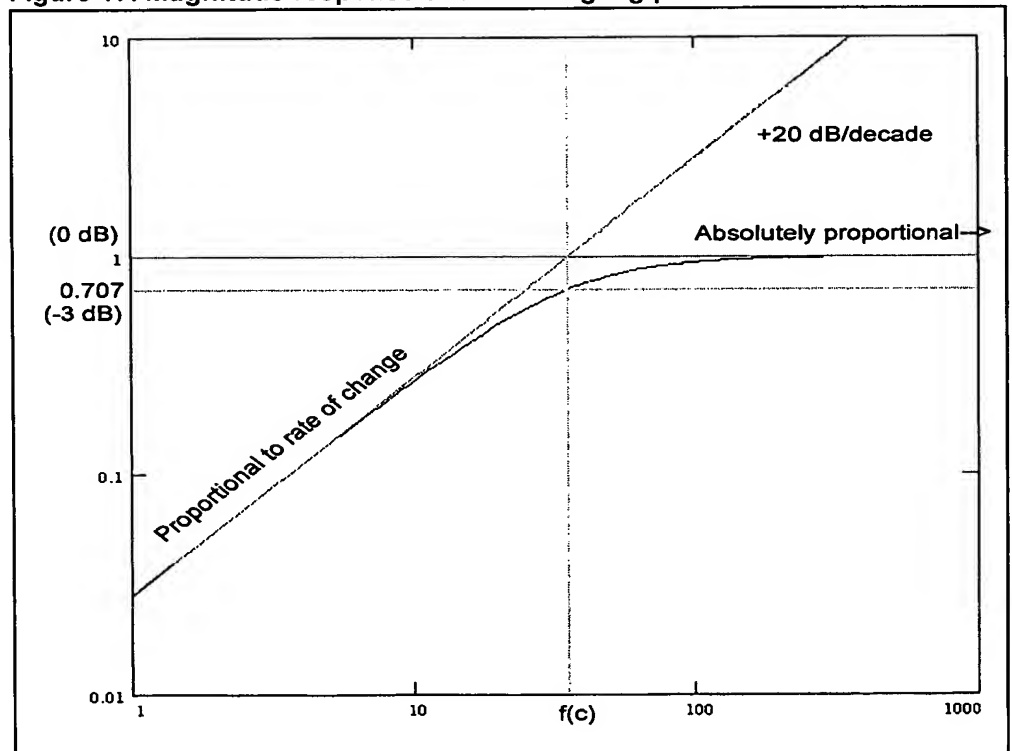


Figure 17. Magnitude response shown as log/log plot



Analysis of the log/log R-C frequency response curve

Some key features:

- # the overall characteristic of this network is known as a high-pass filter
- # the frequency at which the magnitude falls to 0.707 or -3 dB is known as the "cut-off" or "corner" frequency of the high-pass filter
- # this frequency can be calculated as $f(c) = 1/(2\pi RC)$, when both the resistance R and capacitance C are known
- # at frequencies well *below* the cut-off frequency, the plot has the form of a straight line with gradient +20 dB/decade (in other words, doubling the frequency will double the signal amplitude) - this characteristic is identical with that of a *differentiator* network, and gives an output which is proportional to the *rate of change* of the input quantity
- # at frequencies well *above* the cut-off frequency, the plot is level at "unity gain" and the output is directly proportional to the input quantity
- # the filter characteristic can be approximated by these two intersecting straight lines, but the magnitude actually follows an asymptotic curve, with magnitude -3 dB at the cut-off frequency where the straight lines cross
- # the filter characteristic can then be applied to the frequency-domain description of any practical signal by multiplying the filter transfer characteristic with the spectrum of the input signal, and deriving a response curve (output) which can in turn be transformed back into a time-domain signal.

Some practical examples of the effect of this filter characteristic will be shown next. For each signal, the time-domain description of the "perfect source" (e.g. the waveform which would be seen on an oscilloscope if the filter characteristic was absent) is given first, followed by its spectrum (obtained by use of the FFT [Fast Fourier Transform] algorithm supplied in the analysis software), then the filter characteristic (identical for all examples, but shown to emphasize the effect), then the resulting output signal spectrum obtained by multiplying the complex input spectrum by the complex filter characteristic, and finally the corresponding time-domain description obtained by inverse FFT, which shows the waveform an engineer would expect to observe in reality.

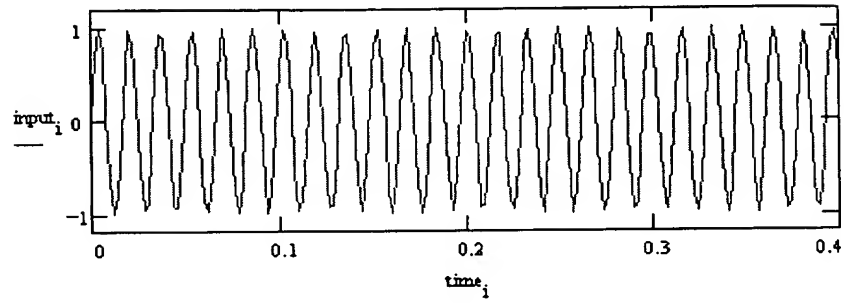
Note: in Figures 15, 16 and 17 the R-C values used to generate the curve were $R = 1\text{M}\Omega$ and $C = 4.5\text{ nF}$. In the following plots, the value of C was reduced to 1.5 nF. These values were chosen somewhat arbitrarily to demonstrate the principle, and so the scaling on the curves has not been annotated. But the time waveforms can be read in x units of seconds, and the frequency curves with x units of Hz. The cut-off frequency for $R = 1\text{M}\Omega$ and $C = 1.5\text{ nF}$ is approximately 106 Hz.

Key to following figures

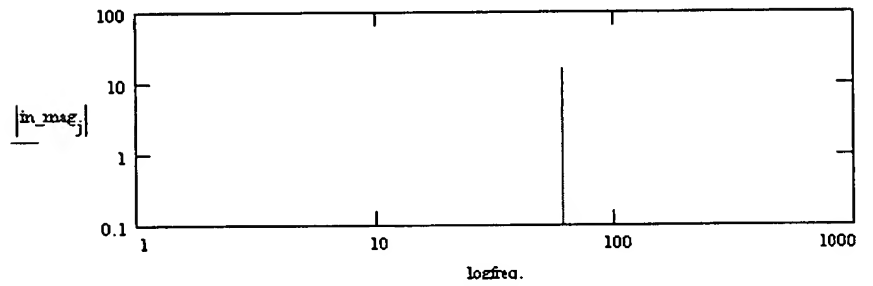
- Figure 18** shows a relatively high-frequency sine wave passing through the network. In the input spectrum, the signal is represented by a single spectral line at the appropriate frequency. This frequency is just below the filter "cut-off", and so is only slightly attenuated by the network. The resulting output wave is diminished in amplitude, and slightly shifted in phase.
- Figure 19** shows the same process applied to a slower sine wave. In this case, the attenuation is much greater, and the phase shift more significant. This situation occurs when trying to monitor steady vibration at "too low" a frequency using a piezo sensor. The phase behavior may be significant if a control loop is to be implemented.
- Figure 20** shows a harmonic series, with a number of discrete spectral lines all lying below the cut-off frequency. Each is attenuated to a different extent, and so the "balance" of harmonics in the output signal is altered.
- Figure 21** shows a slow half-sine input pulse (typical of many mechanical impact signals). Although the high-frequency content is largely unaltered, the output waveform appears heavily "distorted" and clearly shows both positive and negative excursions, whereas the input waveform is unipolar.
- Figure 22** shows a sawtooth waveform with slowly rising "leading edge" followed by a "snap" descent back to zero. Many piezo switches detect this form of mechanical event. In the output waveform, the "leading edge" has almost disappeared, but the "snap" gives almost full amplitude. Note the polarity of the output pulse relative to the input waveform.

Figure 18. Effect of R-C filter on High Frequency Sine Wave input waveform

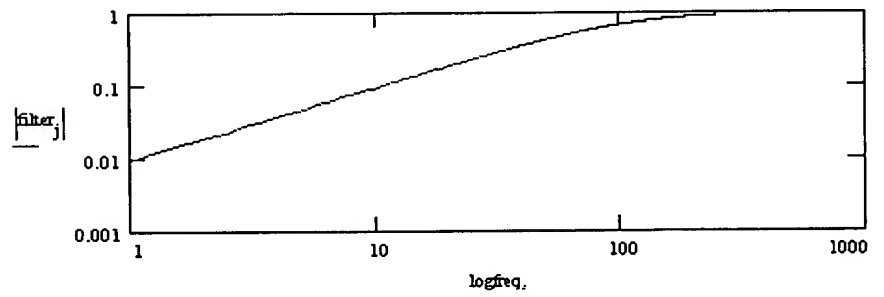
a) Input waveform



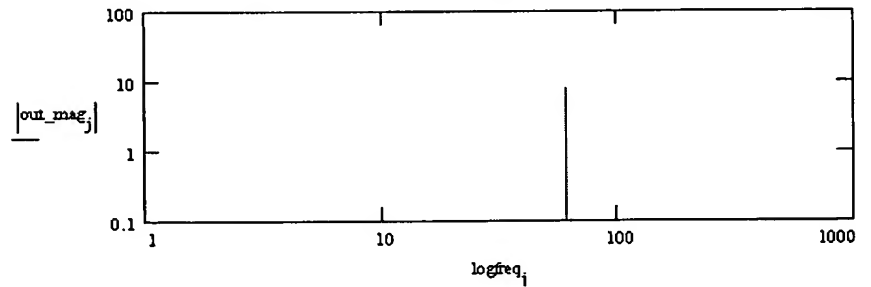
b) Input spectrum



c) Filter characteristic



d) Output spectrum



e) Output waveform

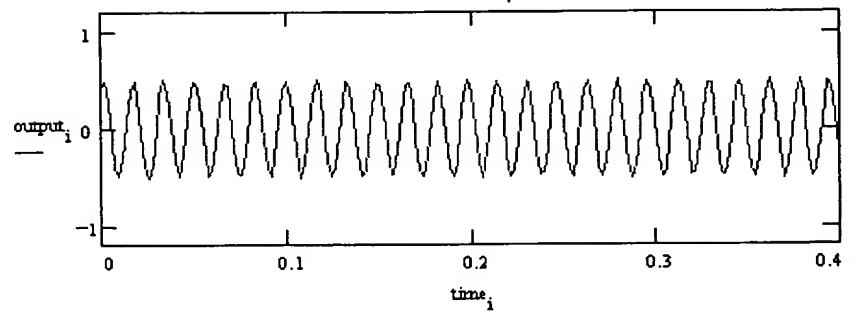
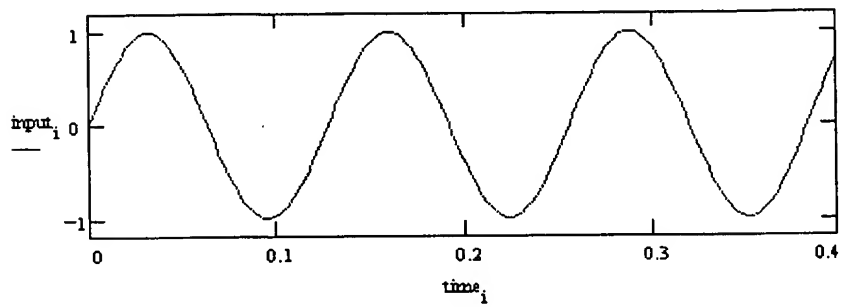
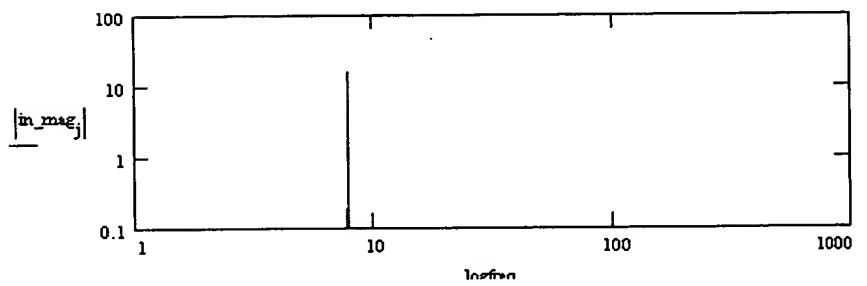


Figure 19. Effect of R-C filter on Low Frequency Sine Wave input waveform

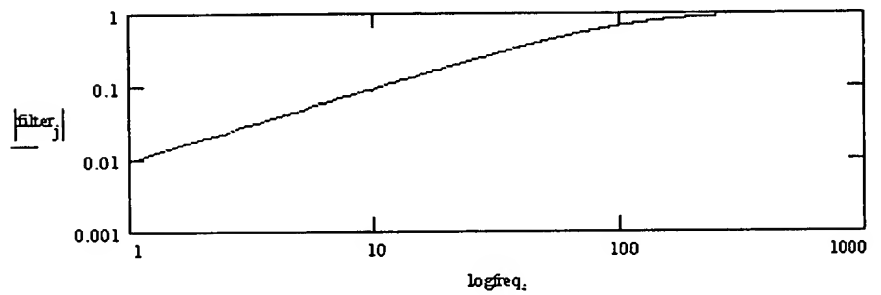
a) Input waveform



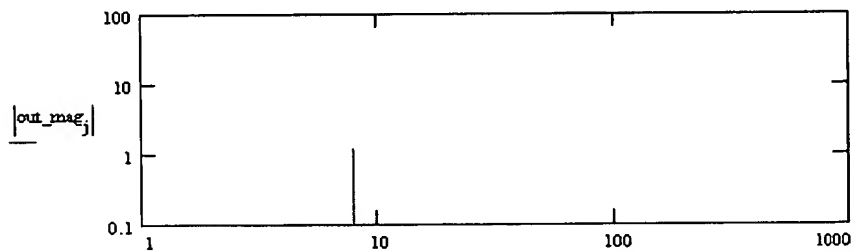
b) Input spectrum



c) Filter characteristic



d) Output spectrum



e) Output waveform

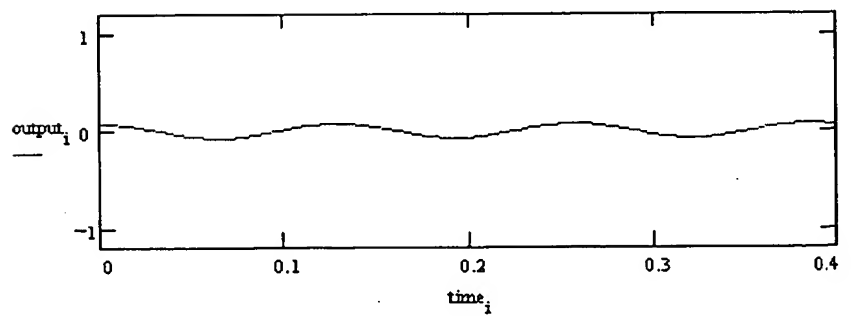
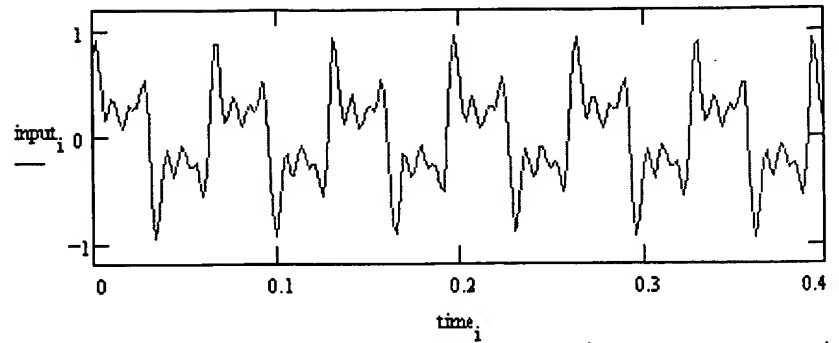
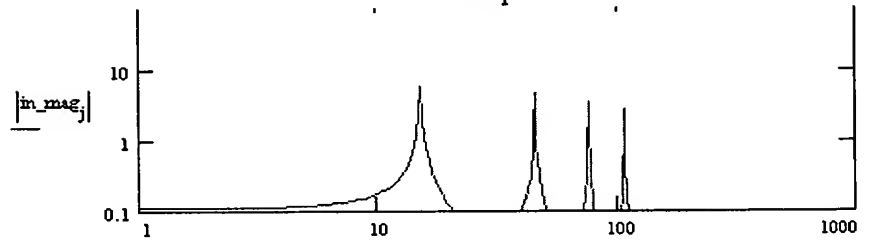


Figure 20. Effect of R-C filter on Harmonic Series input waveform

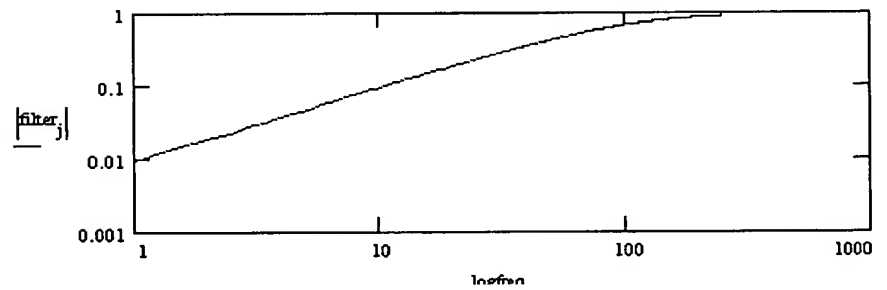
a) Input waveform



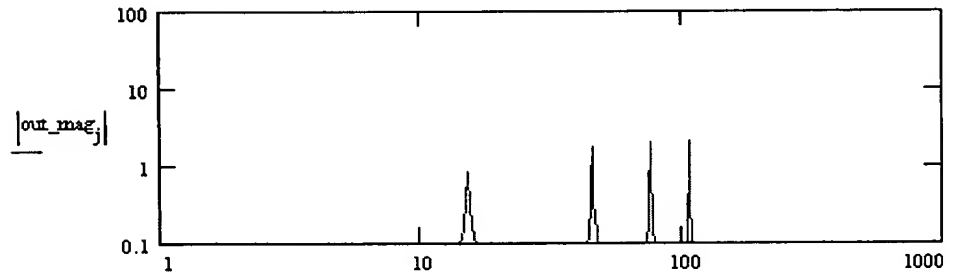
b) Input spectrum



c) Filter characteristic



d) Output spectrum



e) Output waveform

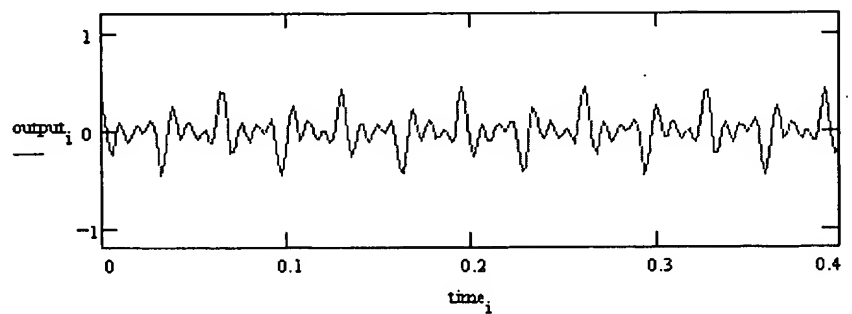
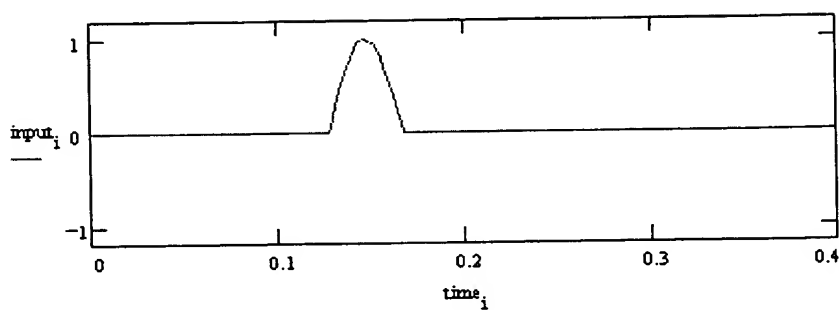
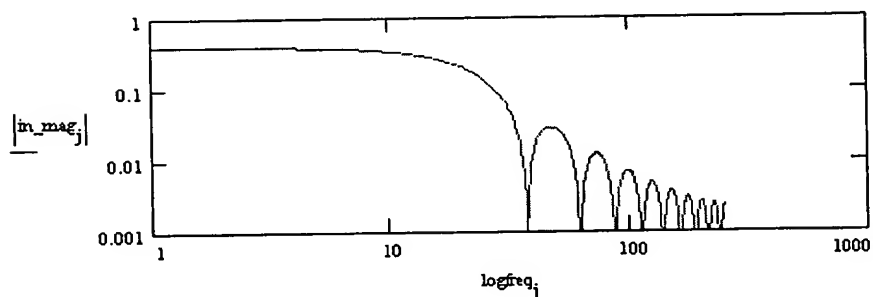


Figure 21. Effect of R-C filter on Slow Half-Sine Transient input waveform

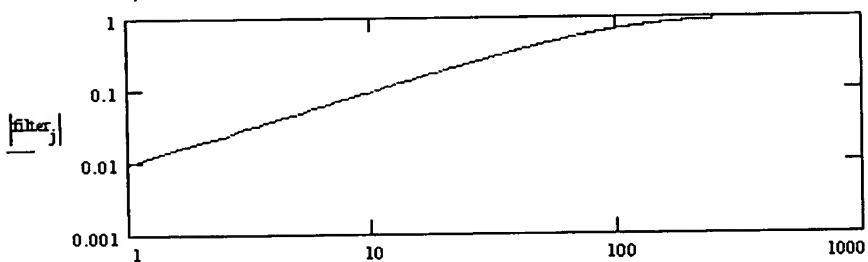
a) Input waveform



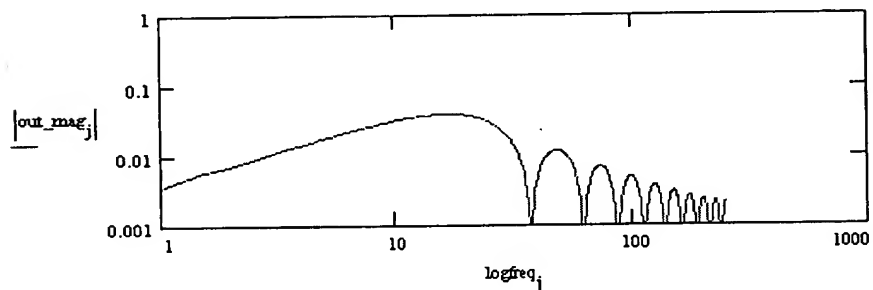
b) Input spectrum



c) Filter characteristic



d) Output spectrum



e) Output waveform

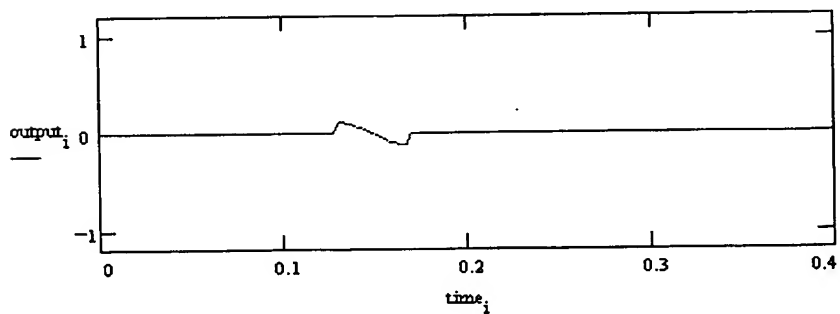
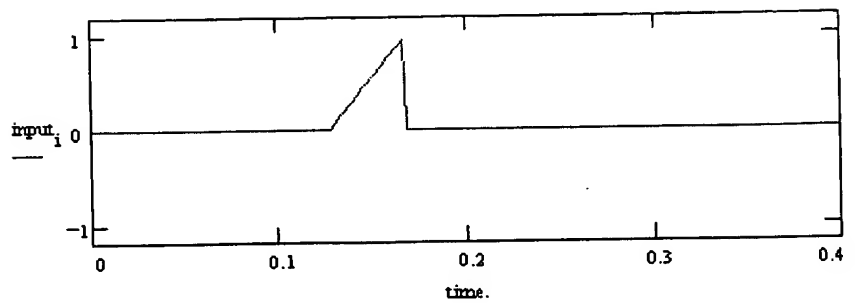
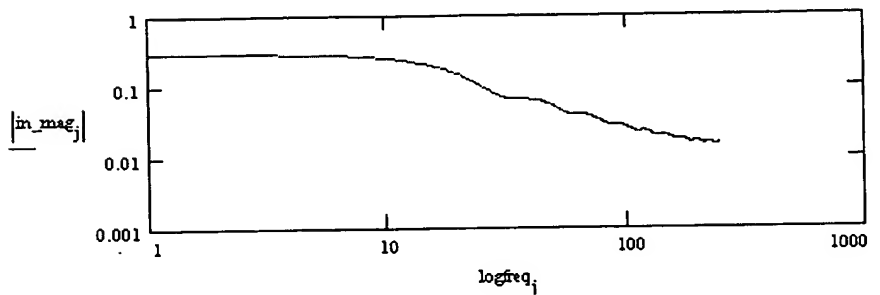


Figure 22. Effect of R-C filter on Slow Sawtooth Transient input waveform

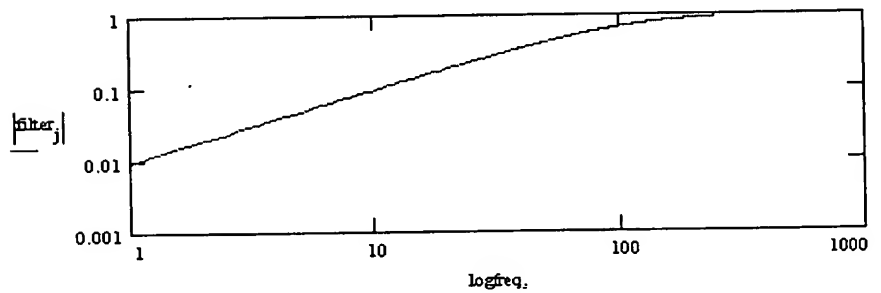
a) Input waveform



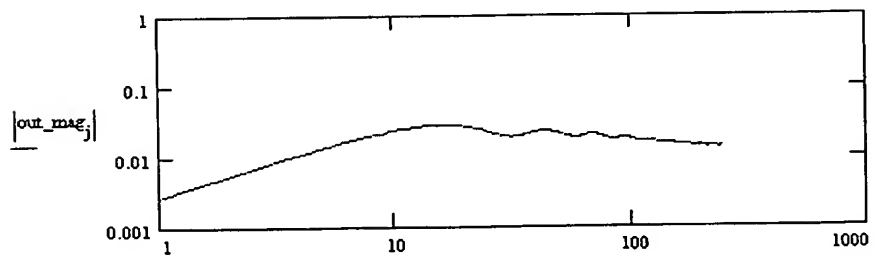
b) Input spectrum



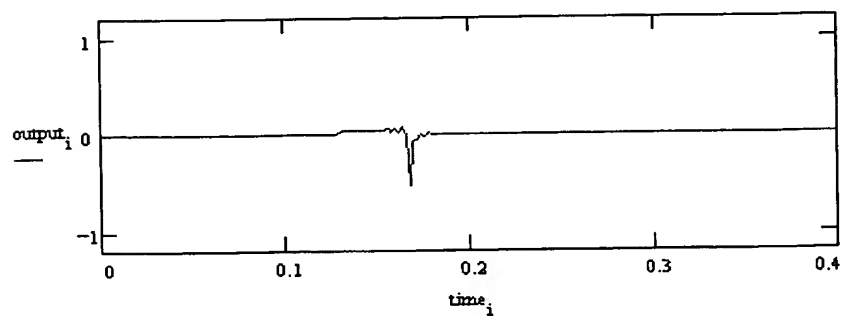
c) Filter characteristic



d) Output spectrum



e) Output waveform

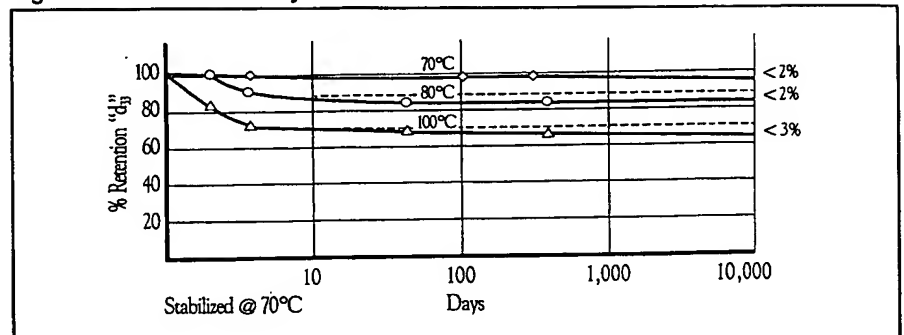


TEMPERATURE EFFECTS

Many of the properties of piezo film change with excitation frequency and temperature. These properties are reversible and repeatable with either frequency or temperature cycling.

In addition, Figure 23 shows the permanent decay of the piezoelectric strain constant d_{33} for PVDF, annealed at 70°C, after long term exposure to elevated temperatures.

Figure 23. Thermal stability of d_{33} constant - 70°C annealed PVDF



Having reached a stabilizing temperature, the material properties then remain constant with time. Piezo film can be annealed to specific operating (or maximum storage) temperatures to achieve long-term stability for high temperature applications. Figure 24 shows the reversible temperature effects on d_{33} and g_{31} coefficients for PVDF.

In Figures 25a and 25b, the effect of temperature on the dielectric constant (ϵ/ϵ_0) and dissipation factor ($\tan \delta_e$) are shown for copolymer films.

Piezo films have been shown to offer excellent transducer properties at very low (cryogenic) temperatures.

Figure 24. Temperature coefficient for d_{33} and g_{31} constants - PVDF

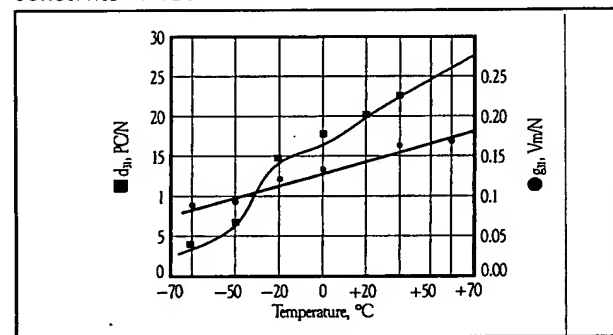


Figure 25a. Dielectric loss tangent vs. temperature COPOLYMER

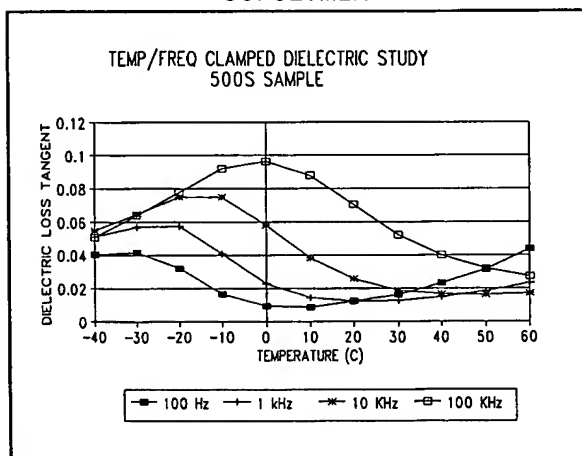
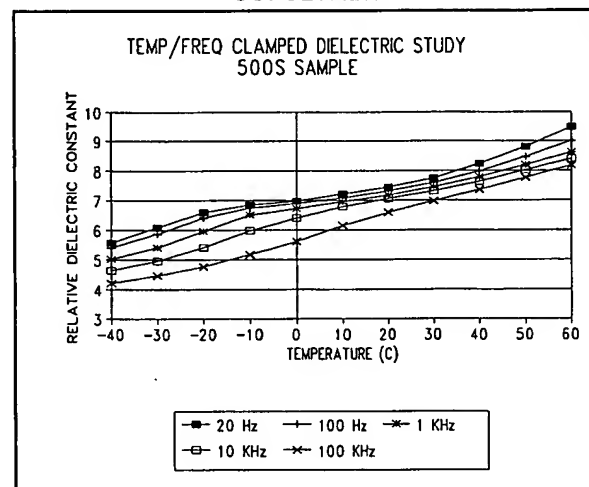


Figure 25b. Dielectric constant vs. temperature COPOLYMER



PIEZOELECTRIC CABLE AND PROPERTIES

One of the most recent developments in piezo polymer technology is piezo cable. The cable has the appearance of standard coaxial cable, but is constructed with a piezoelectric polymer insulator between the copper braid outer shield and the inner conductor (Figure 26).

Protected by a rugged polyethylene jacket, the cable is used in buried or fence security systems, traffic sensors including vehicle classification and weight-in-motion systems, and taxiway sensors for aircraft identification, safety and security applications. Other applications include sensors for anti-tampering, door edge safety monitoring, floor mats, touch pads and panels, and patient mattress monitors. The new cables feature the same piezoelectric properties that are characteristic of piezo film sensors. The electrical output is proportional to the stress imparted to the cable. The long, thin piezoelectric insulating layer provides a relatively low output impedance (600 pF/m), unusual for a piezoelectric device. The dynamic range of the cable is substantial (>200 dB), sensing distant, small amplitude vibrations caused by rain or hail, yet responding linearly to the impacts of heavy trucks. The cables have withstood pressures of 100 MPa. The typical operating temperature range is -40 to +125°C. Table 4 lists typical properties for piezo cable.

Figure 26. Piezo cable construction

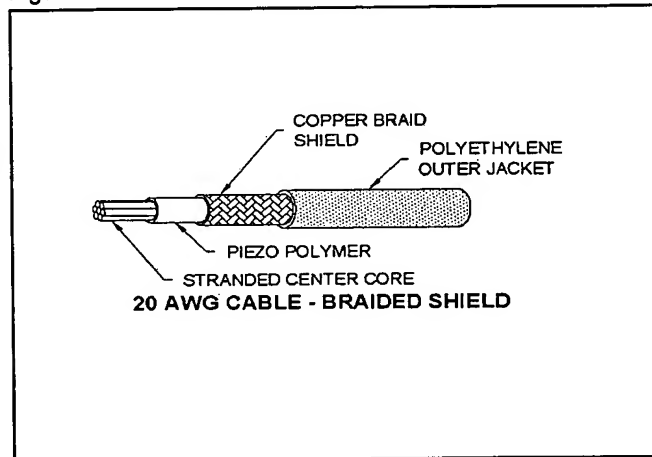


Table 4. Piezo Cable Typical Properties

Parameter	Units	Value
Capacitance @ 1KHz	pF/m	600
Tensile Strength	MPa	60
Young's Modulus	GPa	2.3
Density	kg/m ³	1890
Acoustic Impedance	MRayl	4.0
Relative Permittivity	@1KHz	9
tan δ_e	@1KHz	0.017
Hydrostatic Piezo Coefficient	pC/N	15
Longitudinal Piezo Coefficient	Vm/N	250 x 10 ⁻³
Hydrostatic Piezo Coefficient	Vm/N	150 x 10 ⁻³
Electromechanical Coupling	%	20
Energy Output	mJ/Strain (%)	10
Voltage Output	kV/Strain (%)	5

Cable Typical Properties

The output sensitivity of piezo cable in response to increasing impact load is shown in Figure 27a. The linearity in output for increasing force as shown in Figure 27b is typical of all piezo cable gages.

PIEZOELECTRIC BASICS

Figure 27a. Sensitivity vs. load

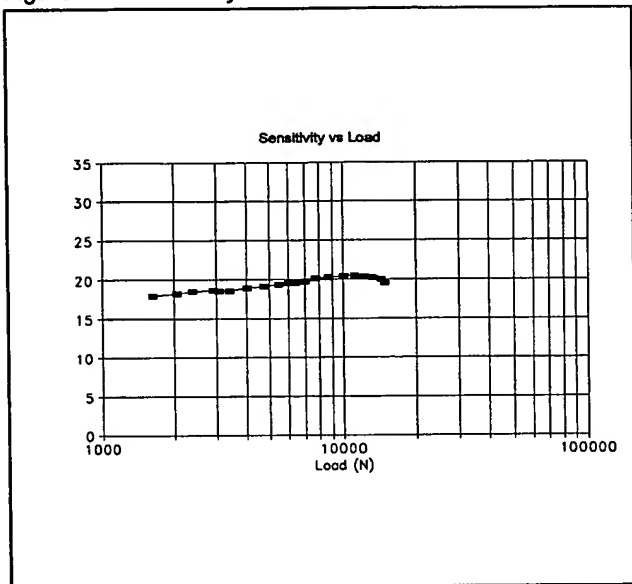
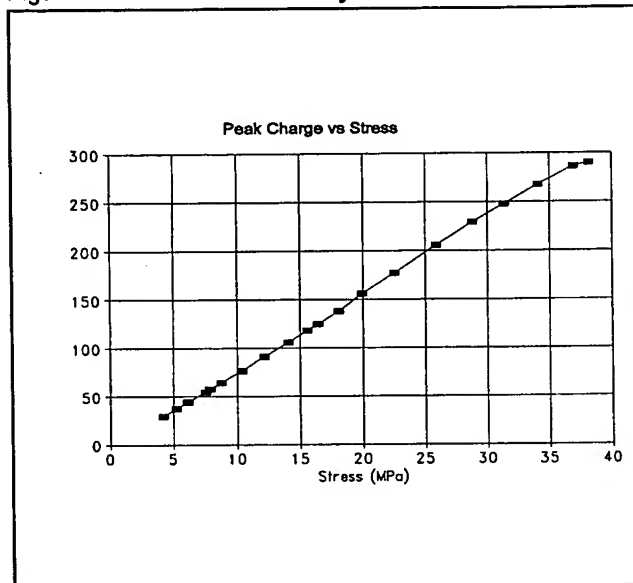


Figure 27b. Piezo cable linearity



Mechanical to Electrical

Like water from a sponge, piezoelectric materials generate charge when squeezed. The amplitude and frequency of the signal is directly proportional to the mechanical deformation of the piezoelectric material. The resulting deformation causes a change in the surface charge density of the material so that a voltage appears between the electroded surfaces. When the force is reversed, the output voltage is of opposite polarity. A reciprocating force thus results in an alternating output voltage.

Piezo film, like all piezoelectric materials, is a dynamic material that develops an electrical charge proportional to a change in mechanical stress. Piezoelectric materials are not suitable static measurements (true dc) due to their internal resistance. The electrical charges developed by piezo film decay with a time constant that is determined by the dielectric constant and the internal resistance of the film, as well as the input impedance of the interface electronics to which the film is connected. Practically speaking, the lowest frequency measurable with piezo film is in the order of 0.001Hz. There are methods to achieve true dc response, but these require using the piezo film as both an actuator and sensor, monitoring change in the actuation resulting from the dc event.

The fundamental piezoelectric coefficients for charge or voltage predict, for small stress (or strain) levels, the charge density (charge per unit area) or voltage field (voltage per unit thickness) developed by the piezo polymer.

Charge Mode:

Under conditions approaching a short circuit, the generated charge density is given by:

$$D = Q/A = d_{3n}X_n \quad (n = 1, 2, \text{ or } 3)$$

The mechanical axis (n) of the applied stress (or strain), by convention, is:

- 1 = length (or stretch) direction
- 2 = width (or transverse) direction
- 3 = thickness direction

where

D = charge density developed

Q = charge developed

A = conductive electrode area

d_{3n} = appropriate piezoelectric coefficient for the axis of applied stress or strain

n = axis of applied stress or strain

X_n = stress applied in the relevant direction

It is important to note that the d_{3n} coefficient is commonly expressed in pico-Coulombs per Newton (pC/N), but the more correct form would be $(\text{pC/m}^2)/(\text{N/m}^2)$ since the areas (m^2) upon which the stresses or strains apply are very often different and cannot be "canceled".

Voltage Mode:

The open-circuit output voltage is given by:

$$V_o = g_{3n}X_nt \quad (n = 1, 2, \text{ or } 3, \text{ as above})$$

where

g = appropriate piezoelectric coefficient for the axis of applied stress or strain

X_n = applied stress in the relevant direction

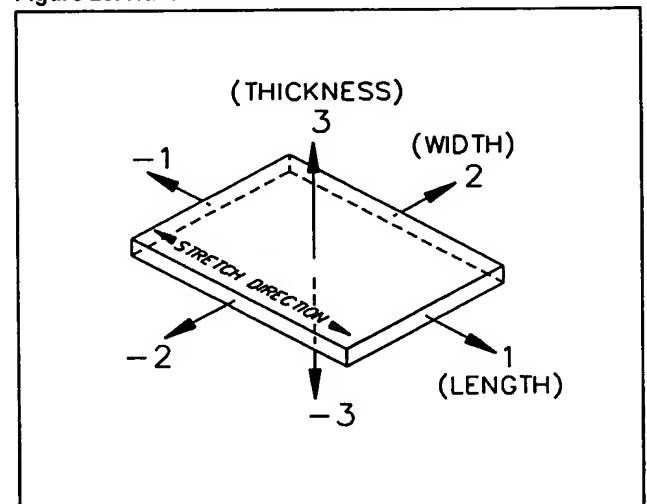
t = the film thickness

Piezo Coefficients:

The most widely used piezo coefficients, d_{3n} and g_{3n} , charge and voltage respectively, possess two subscripts. The first refers to the electrical axis, while the second subscript refers to the mechanical axis. Because piezo film is thin, the electrodes are only applied to the top and bottom film surfaces. Accordingly, the electrical axis is always "3", as the charge or voltage is always transferred through the thickness ($n = 3$) of the film. The mechanical axis can be either 1, 2, or 3, since the stress can be applied to any of these axes, as shown in Figure 28.

Typically, piezo film is used in the mechanical 1 direction for low frequency sensing and actuation ($< 100\text{KHz}$) and in the mechanical 3 direction for high ultrasound sensing and actuation ($> 100\text{KHz}$).

Figure 28. Numerical classification of axes



Directionality:

Piezoelectric materials are anisotropic. This means that their electrical and mechanical responses differ depending upon the axis of applied electrical field or axis of mechanical stress or strain. Calculations involving piezo activity must account for this directionality.

EXAMPLE 1:

A 1.45 psi load ($10,000 \text{ N/m}^2$) is applied to a piezo film switch of 2.54 cm length, 2.54 cm width and $110 \mu\text{m}$ in film thickness. The switch element is rigidly backed, so the force acts to compress the film's thickness (therefore g_{33} mode). In this example the load acts on the length by width area of the piezo film. The open circuit voltage developed across the thickness of the piezo film is:

$$V_o = -g_{33} X t$$

$$g_{33} = -339 \times 10^{-3} \frac{\text{V/m}}{\text{N/m}^2}$$

where:

V/m is Volts out per meter of piezo film thickness

N/m^2 is stress applied to the relevant film area. The conversion from psi to N/m^2 is approximately 7,000.

$$V_o = - \left(-339 \times 10^{-3} \frac{\text{V/m}}{\text{N/m}^2} \right) (-10,000 \text{ N/m}^2) (110 \times 10^{-6} \text{ m})$$
$$V = -0.373 \text{ volts}$$

EXAMPLE 2:

The same piezo film element as in EXAMPLE 1 is subjected to a force ($10,000 \text{ N/m}^2 \times 0.0254 \text{ m}^2 = 6.45 \text{ Newtons}$), but in this example, the film switch is configured as a membrane having a compliant backing. Now, the force acts on the thickness cross-sectional area (wt). The piezo film is being stretched by the load, so it is acting in the g_{31} mode.

$$V_o = -(3g_{31} \left(\frac{F}{wt} \right) t) = -(g_{31}) \left(\frac{F}{w} \right)$$

$$g_{31} = 216 \times 10^{-3} \frac{\text{V/m}}{\text{N/m}^2}$$

$$V_o = - \left(216 \times 10^{-3} \frac{\text{V/m}}{\text{N/m}^2} \right) \left(\frac{6.45 \text{ N}}{2.54 \times 10^{-2} \text{ m}} \right)$$

$$V_o = -54.9 \text{ volts}$$

The sharp increase in output voltage results because the force is applied to the much smaller cross-sectional area of the film. The small area results in a correspondingly higher stress.

Dynamic Range

Piezo film has a vast dynamic range. The sensor has been used to detect the impact of high speed particles in space having a mass of 10^{-12} grams, and at the other extreme, measures shock waves at 300,000 atmospheres produced during weapons testing. A recent study was conducted to determine the maximum output energy of a 52 μ m thick film, having an area of 155.5 mm x 18.5 mm. The film was subjected to approximately 350 MPa (in the stretch or "n=1" direction) without failure. The charge generated was found to be very linear, with the following measurements made at maximum applied stress:

Maximum Charge Observed: 20 μ C, giving 6.95 mC/m²
Maximum Voltage Observed: 1600 V, giving 30.8×10^6 V/m
Maximum Energy Converted: 30.9 mJ, giving 207 kJ/m³

Later experiments showed that about 10% of the above energy levels can be sustained for long periods of time without measurable damage to the piezo film element.

Electrical to Mechanical

When a voltage is applied to a sheet of piezo film, it causes the film to change dimensions due to the attraction or repulsion of internal dipoles to the applied field.. With one voltage polarity is applied, the piezo film becomes thinner, longer and wider. The opposite polarity causes the film to contract in length and width and become thicker. An ac voltage causes the film to "vibrate".

The amount of deformation is given by the piezoelectric "d_{3n}" constant:

for **length** change $\Delta l = l d_{31} V/t$

where

Δl = change in film length in meters
 l = original film length in meters
 d_{31} = piezoelectric coefficient for length ("n=1" direction) change in meters per volt
 V = applied voltage across the thickness (t)

for **width** change $\Delta w = w d_{32} V/t$

where

d_{32} = piezoelectric coefficient for width ("n=2" direction) change

for **thickness** change $\Delta t = t d_{33} V/t = d_{33} V$

where

d_{33} = piezoelectric coefficient for thickness ("n=3" direction) change

EXAMPLE 3:

A piezo film of 3 cm length (l), 2 cm width (w) and $9\mu\text{m}$ thickness (t) is subjected to an applied voltage of $V=200$ volts in the 3 (thickness) direction. The amount of strain S resulting from this electrical input is d times the applied field.

In the 1 direction:

$$S_1 = \frac{\Delta l}{l} = d_{31}(V/t) \quad \text{where } d_{31} = 23 \times 10^{-12} \frac{\text{m/m}}{\text{V/m}}$$

$$\Delta l = d_{31}(V/t) l = \left(23 \times 10^{-12} \frac{\text{m/m}}{\text{V/m}} \right) \frac{(200 \text{ V})(3 \times 10^{-2} \text{ m})}{(9 \times 10^{-6} \text{ m})}$$

$$\Delta l = 1.53 \times 10^{-5} \text{ m} \quad \text{or} \quad 15.3 \mu\text{m}$$

In the t direction:

$$\Delta t = t d_{33}(V/t) l = d_{33} V = \left(-33 \times 10^{-12} \frac{\text{m/m}}{\text{V/m}} \right) (200 \text{ V}) = 6.6 \times 10^{-9} \text{ m} \quad \text{or} \quad 66 \text{ \AA}$$

Actuators

Generally, piezo film actuator designs depend on the application requirements such as operating speed, displacement, generated force, and available electrical power. Piezo film technology offers various design options to meet such application requirements. Those design options include:

- ! Customized electrode patterns on one or both sides of the piezo film sheet.
- ! Multilaminate structures or bimorphs.
- ! Fold-over or scrolled multilayer structures.
- ! Extruded piezo tubes and piezo cables.
- ! Cast piezo polymer on various substrates
- ! Molded 3-D structures.

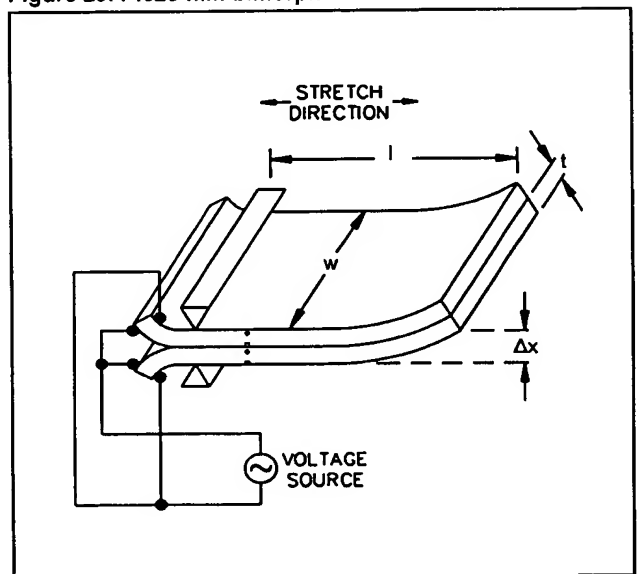
Each design option mentioned above has advantages and disadvantages. For example, scrolled multilayer actuators can generate a higher force but may sacrifice some displacement.

Bimorph

Like a bimetal strip, two sheets of piezo film of opposite polarities, adhered together form a bending element, or "bimorph" (Figure 29). An applied voltage causes one film to lengthen, while the other contracts, causing the unit to bend. An applied voltage of opposite polarity bends the bimorph in the opposite direction.

The bimorph configuration converts small length changes into sizable tip deflections, but producing low force.

Figure 29. Piezo film bimorph



Thicker films and multilayers improve the force developed by the bimorph, but sacrifice displacement unless the unit can be operated at higher fields.

The amount of tip deflection and the force developed are given by:

$$\Delta x = 3/4 d_{31} (l^2/t^2) V \quad \text{meters}$$

and

$$F = 3/2 Y w d_{31} (t/l) V \quad \text{Newtons}$$

where

- Δx = displacement at dc
- F = generated force
- d_{31} = piezoelectric coefficient in the "1" direction
- l, t, w = length, thickness, and width of piezo film
- V = applied voltage (Volts)
- Y = Young's modulus of piezo film ($2 \times 10^9 \text{ N/m}^2$)

By applying an ac voltage, the bimorph can act as a fan, similar to an insect wing. Although the piezo film bimorph does exhibit a dc response, maximum tip deflections are obtained when the unit is operated at resonance, determined by the length and thickness of the bimorph beam.

EXAMPLE 4:

100 volts are applied across a 2 cm long cantilever bimorph comprised of two strips of $9 \mu\text{m}$ PVDF. The resultant tip displacement Δx is:

$$\Delta x = \frac{3/4 V d_{31} l^2}{t^2}$$

$$\Delta x = \frac{3/4 (100 \text{ V}) \left(23 \times 10^{-12} \frac{\text{m/m}}{\text{V/m}} \right) (2 \times 10^{-2} \text{ m})^2}{(9 \times 10^{-6} \text{ m})^2}$$

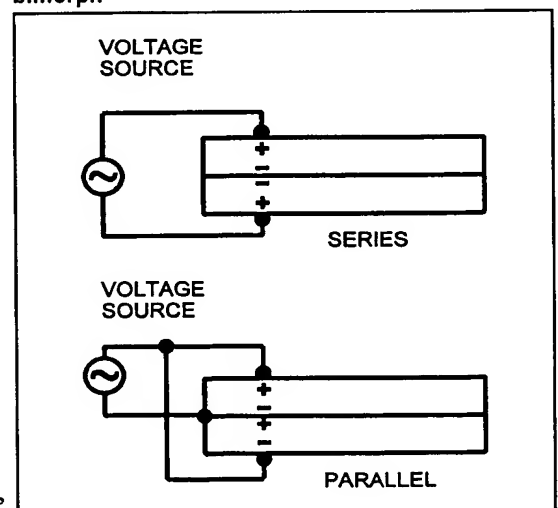
$$\Delta x = 8.52 \text{ mm}$$

As shown in the equations, more displacement can be obtained from a longer bimorph. Larger forces can be obtained from a wider bimorph. The ratio of displacement at a resonance frequency and dc is defined by Q which indicates a mechanical gain. A typical Q value for a piezo film bimorph is 20 to 25.

For example, a 5 mm long $70 \mu\text{m}$ thick bimorph with 120 volts dc creates a displacement of $57 \mu\text{m}$. With the same bimorph, however, displacement can be 1.4 mm at the resonant frequency of 580 Hz. For applications that require a higher force, such as cooling fans, multilayer construction can be considered. The resulting output force is proportionally increased by the number of layers.

In terms of electrical connections to the bimorph, there are two basic methods as shown in Figure 30 — parallel and series connections. In order to generate the same amount of displacement, the parallel connection requires a lower voltage than the series connection. Series connections, on the other hand,

Figure 30. Lead attachment methods for a bimorph



draw less current than parallel connections. For both parallel and series connections, the total electrical power to the actuator is identical. However, it is obvious that the lead attachment of the series connection is much simpler than that of the parallel connection for manufacturing purposes. Typical applications of the bimorph bender are cooling fans, toys, and decoratives.

Scrolled Actuator

The generated force and displacement of a scrolled piezoelectric cylinder in Figure 31 are expressed as follows:

$$x = d_{31}El \quad \text{Meters}$$

$$E = V/t \quad \text{Volts/meters}$$

$$F = Yd_{31}EA \quad \text{Newtons}$$

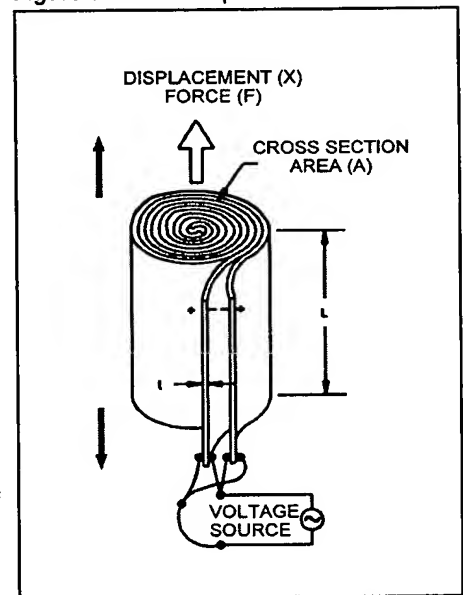
$$f = (1/2\pi)\sqrt{YA/l(M_e + 0.405M_p)}$$

where

- x = displacement at dc (meter)
- F = generated force (Newton)
- f = resonance frequency
- l, t = Length, thickness of piezo film (meters)
- M_e = externally loaded mass (kilograms)
- M_p = piezo actuator mass (kilograms)
- A = cross sectional area (m^2)
- Y = Young's modulus (N/m^2)
- E = electrical field (volt/meter)

As shown in the equations, a scrolled actuator can generate more force and can respond with a higher resonant frequency by increasing the cross sectional area. A longer actuator generates more displacement but reduces the response speed. Note that the actuator output, with $M_e = 0$, will be maximized when the length l is adjusted to satisfy the resonant condition. As an example, the performance of a 12 mm diameter, 25 mm long scrolled actuator can be maximized at 32 KHz operation.

Figure 31. Scrolled piezo film actuator



Folded Actuator

Another design option for a high speed, high force actuator is to fold over a long sheet of piezo film as shown in Figure 32. This design effectively creates a parallel wired stack of piezo film discs. The center hole is used to secure the actuator to a base. Design equations of the scrolled actuator also can be applied to this type of actuator. In the previous equations, d_{31} should be replaced with d_{33} ($-33 \times 10^{-12} C/m^2$) for a folded actuator. An example of specifications for the folded actuator is shown below:

- Displacement: $1 \mu m/1 \text{ mm length}$
- Generated force: $15 \text{ kg}/10 \text{ mm dia.}$
- Frequency: dc - 100 kHz
- Drive voltage: 800 volts

Compared to mechanical or piezo ceramic actuators, multilayer piezo film actuators have fewer ringing problems due to their lower Q. Applications of multilayer actuators are micropositioners for industrial equipment, acoustic wave generators and ink jet printers.

Ultrasonic Actuators

Ultrasonic actuators, as discussed in this section, exclude very high frequency (> 1 MHz) transmitter applications. The use of piezo film in these very high frequency applications, like medical ultrasound imaging and nondestructive testing, use thickness mode operation, d_{33} . This section deals with low frequency ultrasound (20-100 KHz) where the piezo film can be used in the length change (d_{31}) mode.

The advantage of piezo film in low frequency ultrasound can be found from the flexibility of the material. Piezo film can be easily curved or formed to make circular transducers as shown in Figure 33. The beam pattern is determined by the number of half circular elements and their diameter. The operating frequency is determined by the diameter of the half circular elements. Note that the difference between Figures 33(a) and 33(b) is their number of active elements and diameters. To widen the beam coverage, the number of active elements should be reduced. With a cylindrical transducer, a 360° beam pattern is obtained.

In ultrasound applications, a narrow beam with minimum side lobes is required for remote distance measurements. On the other hand, a wide beam, as wide as 180° or more, is required for applications like automobile rear bumper proximity sensing. Figure 33 shows design configurations for both narrow beam and wide beam ultrasound transducers. The applications for piezo film in through-air ultrasonic actuators include distance ranging for air pen, air mouse, white board digitizer, collision avoidance, physical security systems, air flow velocity (doppler) sensors, and inter-object communications. Similar constructions can be produced for underwater or fluid sensing, including flow sensors, level sensors, and communications.

Figure 32. Folded piezo film actuator

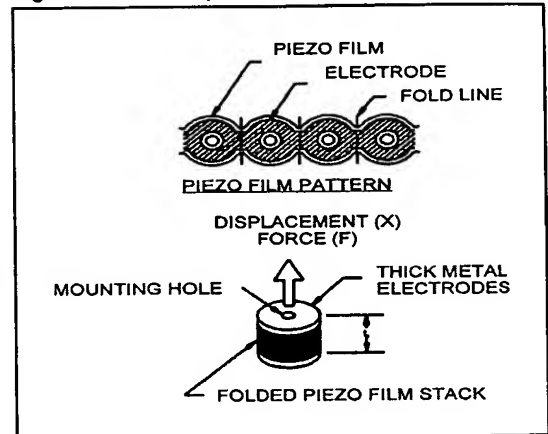
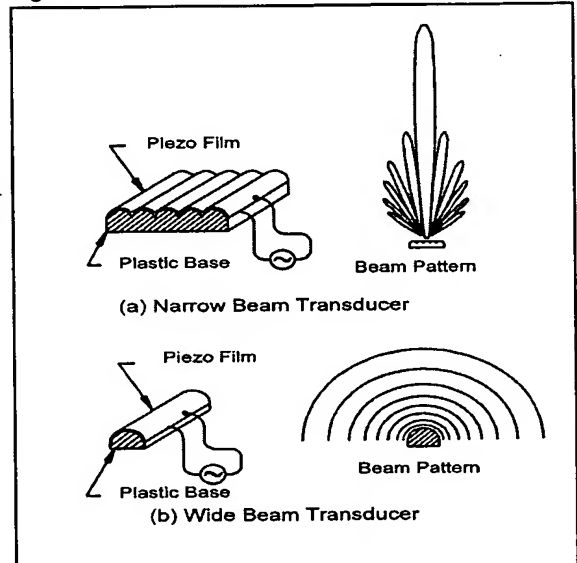


Figure 33. Piezo film ultrasound transducers



PYROELECTRIC BASICS

Piezoelectric polymers, such as PVDF and its copolymers of VF_2/VF_3 , are also pyroelectric. Pyroelectric sensor materials are normally dielectric materials with a temperature-dependent dipole moment. As these materials absorb thermal energy, they expand or contract, thereby inducing secondary piezoelectric signals. As piezo film is heated, the dipoles within the film exhibit random motion by thermal agitation. This causes a reduction in the average polarization of the film, generating a charge build up on the film surfaces. The output current is proportional to the rate of temperature change (ΔT). The amount of electrical charge produced per degree of temperature increase (or decrease) is described by the pyroelectric charge coefficient, ρ .

The charge and voltage produced in a given film of area A permittivity ϵ , and thickness t is given by

$$Q = p\Delta TA$$

$$V = pt\Delta T/\epsilon$$

EXAMPLE 5:

A piezo film pyroelectric detector having a film thickness (t) of $9\mu\text{m}$, a permittivity (ϵ) of $106 \times 10^{-12} \text{ C/Vm}$ and a pyroelectric coefficient (p) of $30 \times 10^{-6} \text{ C/(m}^2\text{°K)}$, undergoes a temperature increase (ΔT) of 1°K due to incident IR radiation. The output voltage is given by:

$$V = \frac{(30 \times 10^{-6} \text{ C/m}^2\text{°K})(9 \times 10^{-6} \text{ m})(1^\circ\text{K})}{(106 \times 10^{-12} \text{ C/Vm})}$$

$$V = 2.55 \text{ volts}$$

The pyroelectric voltage coefficient of piezo film is about an order of magnitude larger than those of Lead Zirconate Titanate (PZT) and Barium Titanate (BaTiO_3). Table 5 compares the pyroelectric properties of these materials, but a far lower figure of merit due to the low capacitance of PVDF.

Table 5. Comparison of pyroelectric materials

Material	TGS	LiTaO_3	BaTiO_3	PZT	PbTiO_3	PVDF	VF_2VF_3
ρ_Q	350	200	400	420	230	30	50
ϵ/ϵ_0	30	45	1000	1600	200	10.7	8.0
α	.16	1.31	1.00	.44	.67	.06	.06
L	225	646	564	374	461	138	138
P_v	1.32	.50	.05	.03	.10	.47	.71
M_l	.53	.16	.02	.01	.03	.20	.31
Pyroelectric Charge Coefficient				$(\rho_Q)\mu\text{Coul}/[\text{m}^2\text{°K}]$			
Dielectric Constant				(ϵ/ϵ_0) , where $\epsilon_0 = 8.85\text{pF/m}$			
Thermal Diffusivity				$(\alpha)\text{m}^2/\text{sec} \cdot 10^{-6}$			
Thermal Diffusion Depth @ 1Hz				$(L)\mu\text{m}$			
Pyroelectric Voltage Coefficient				$(P_v)\rho_Q/\epsilon, \text{V}/[\mu\text{m} \cdot \text{°K}]$			
Figure of Merit				$(M_l)\rho_Q/[C_v \cdot \epsilon], \text{V} \cdot \text{mm}^2/\text{J}$			

Piezo film advantages including:

- moisture insensitivity (<.02% H₂O absorption)
- low thermal conductivity
- low dielectric constant
- chemical inertness
- large detector sizes

The pyroelectric response of piezo film can also become a noise source for piezo sensor applications at low frequencies. In piezoelectric applications where low frequency strain sensing is desired, there are several convenient methods to “common-mode reject” the pyroelectric response. Examples include:

- ! Two equal sized electrode patterns on one piezo film element; one electrode oriented parallel to the d_{31} and the other electrode pattern is perpendicular to the d_{31} direction. Both develop equal signals in response to pyro, but the electrode area parallel to the d_{31} develops about 10X the perpendicular electrode pattern. Subtracting the signals yields a pure piezo response.
- ! Two equal sized piezo film elements, laminated in a stacking configuration; one film has d_{31} parallel to strain surface, the other has d_{31} perpendicular to strain surface. As above, signals are subtracted to isolate the piezo response from pyro.
- ! Several other common mode rejection techniques can be described by MSI's applications engineers.

For higher frequencies, where the rate of temperature change seen by the piezo film element is slower than the strain event to be measured, frequency filters readily sort out the unwanted pyro signal.

BASIC CIRCUIT CONCEPTS

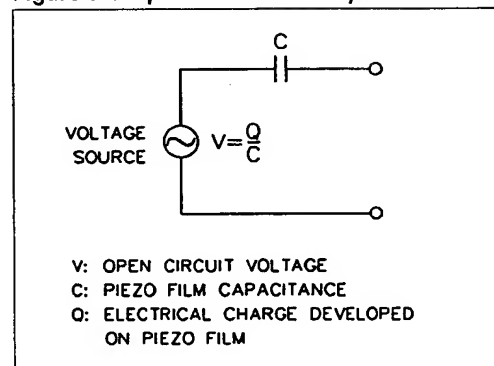
A properly designed interface circuit plays a key role in the optimization of piezo film sensors. The applications of piezo film span from toys to military sensors and interfacing to electronics is highly application dependent. In many cases, piezo film can be directly connected to electronic circuits without special interface considerations. However, for those cases where an interface circuit is required, the following 3 steps are recommended:

1. Consider the frequency range and signal amplitude requirements over the desired dynamic range.
2. Choose a proper load resistance to assure the low end operating frequency and to minimize signal loss due to the loading effect.
3. Select a buffer circuit if the signal level is small. If a high value load resistance is needed (such as 22M Ω or higher value), a low leakage high impedance buffer amplifier is recommended. JFET's or CMOS operational amplifiers are commercially available for a buffer.

Simplified Equivalent Circuits

The first step in an interface circuit design is to understand the piezo film characteristics as part of an electrical equivalent circuit. Figure 34 shows a simplified equivalent circuit of piezo film. It consists of a series capacitance with a voltage source. The series capacitance C_f represents piezo film capacitance which is proportional to the film

Figure 34. Equivalent circuit of piezo film



permittivity and area and inversely proportional to film thickness. The voltage source amplitude is equal to the open circuit voltage of piezo film and varies from microvolts to 100's of volts, depending on the excitation magnitude. This simplified equivalent circuit is suitable for most applications but is of limited value at very high frequencies such as that used in ultrasound transducers.

Figure 35 shows an equivalent circuit as a charge generator. This equivalent circuit has film capacitance C_f and internal film resistance R_f . The induced charge Q is linearly proportional to the applied force as described earlier. The capacitance C_f is proportional to the surface area of film and is inversely proportional to the film thickness. In low frequency applications, the internal film resistance R_f is very high and can be ignored. The open circuit output voltage can be found from the film capacitance; i.e., $V = Q/C_f$.

Input Resistance

The most critical part of an interface circuit is the input resistance. The input resistance affects low frequency measurement capability as well as signal amplitude. This is called the "loading effect".

Piezo film capacitance can be regarded as an equivalent source impedance. It is important to note that this source impedance increases with decreasing film capacitance and decreasing frequency of operation. This source impedance combined with the input resistance produces a voltage divider. As the ratio of input resistance to source impedance is decreased, the overall output voltage is reduced. Therefore, choosing a proper input resistance for the electronic interface is critical in minimizing the loading effect.

Time Constant

In addition to input resistance, the input capacitance of an interface circuit can also affect the output. Figure 36 shows the equivalent circuit of film with input resistance R_i and input capacitance C_i . A typical time domain response of piezo film is shown in Figure 37. The charge developed on the film due to an applied force decays with a time constant which is defined by $R_i(C_f + C_i)$.

This time constant represents the time required for a signal to decay to 70.7% (-3dB) of its original amplitude. The smaller the time constant, the quicker the signal decays. Because of this finite time constant, piezo film is suitable for dynamic measurements rather than static measurement (0.001 Hz minimum).

If a long time constant is desired, a high input resistance and film capacitance can be used. It should be understood, however, that a high input resistance can also produce higher noise, requiring compensation through shielding, etc.

Figure 35. Equivalent circuit for piezo film

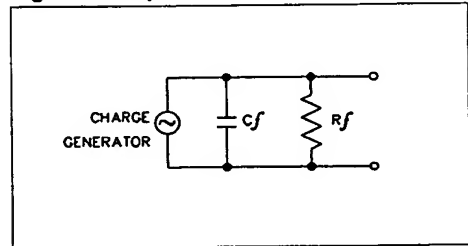


Figure 36. Equivalent circuit of piezo film with input resistance of electronic interface

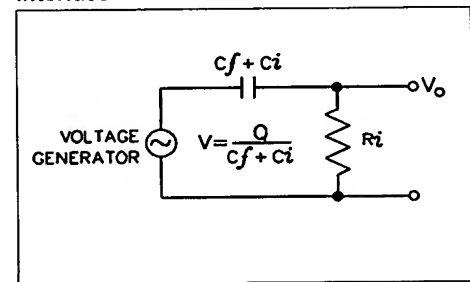
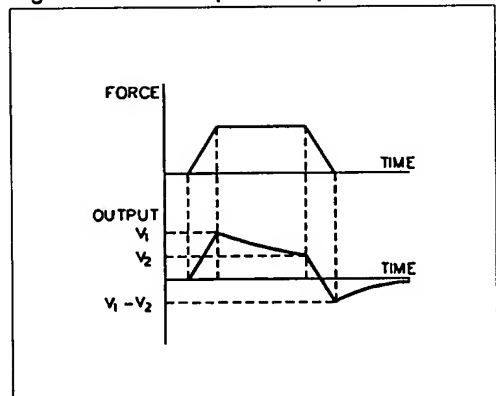


Figure 37. Time response of piezo film



Frequency Response

Another important aspect of the time constant can be seen in the frequency response of the equivalent circuit. The circuit exhibits an RC high-pass filter characteristic as shown in Figure 38. In this figure, the vertical axis implies the ratio of observable output signal to the developed signal (open circuit voltage of the piezo film). Zero dB implies no loss of signal. The cutoff frequency (3 dB down) is inversely proportional to the time constant. When a piezo film sensor is operated below this cut-off frequency, the output signal is significantly reduced. For a low frequency measurement, an input resistance needs to be high enough so that the cut-off frequency is well below the desired operating frequency. This consequence can be verified from consideration of the time constant as well as the loading effect.

As an example, the frequency response of a shielded piezo film sensor (model SDT1) is shown in Figure 39. In this example, the SDT is interfaced with a circuit which contains a $10\text{M}\Omega$ load resistor and an FET. The capacitance of the piezo film is 2.4 nF . With $10\text{M}\Omega$ load resistance, the time constant becomes 24 msec and thus, the cut-off frequency is 6.6 Hz . For comparison, the cut-off frequency can be reduced to 0.66 Hz if a $100\text{M}\Omega$ resistor is used instead of the $10\text{M}\Omega$ resistor. This sensor component can be used for any application operating above the cut-off frequency determined by the resistance value.

In applications where the electronic circuit cannot be placed near the sensor, a buffer circuit is recommended close to the sensor. The buffer circuit converts the high output impedance of the piezo film element into a low output impedance and thus minimizes the signal loss and noise through the cable. For large size (i.e., high capacitance) piezo film sensors a buffer may not be required, even with small signals and long cables.

When a high piezo film output impedance is required, a low-leakage, high impedance buffer is necessary. For example, infrared motion sensor and accelerometer applications require up to $50\text{G}\Omega$ of input resistance to obtain a very low frequency response. For such cases, the input impedance of the buffer must be much higher than the output resistance of the piezo film in order to maintain the low frequency response. In addition, minimum leakage current of the buffer is critical in order to maximize the measurement accuracy. Some examples of low leakage buffer electronics include: JFET - 4117 (Siliconix, Sprague); Operational amplifiers — LMC660, LF353 (National Semiconductor), OP80 (PMI), and 2201 (Texas Instruments).

Figure 40 shows unity gain buffer circuit examples for general applications. Operational amplifiers offer a great deal of versatility as both buffers and amplifiers. They can be used as either charge-mode or voltage-mode amplifiers. Figure 41 shows basic charge and voltage amplifier configurations. The voltage output of the charge

Figure 38. High pass filter characteristic of piezo film

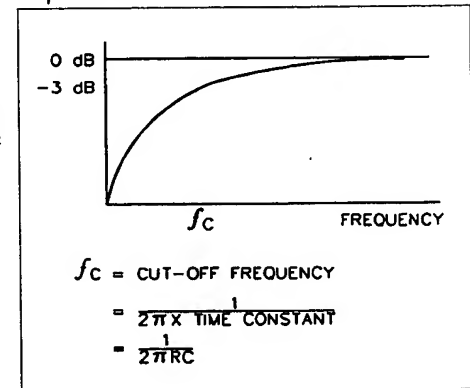


Figure 39. Frequency response of SDT1

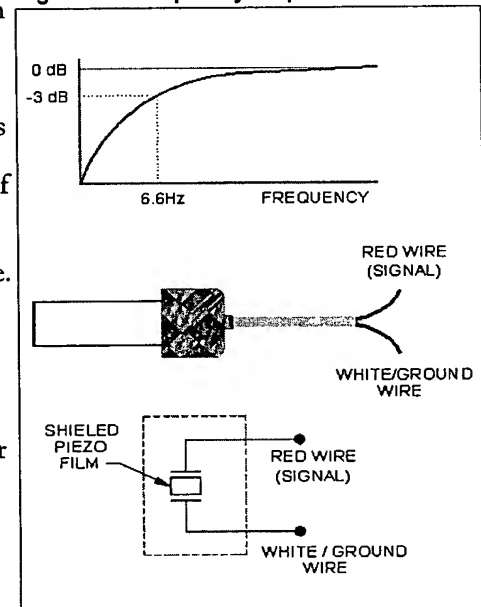
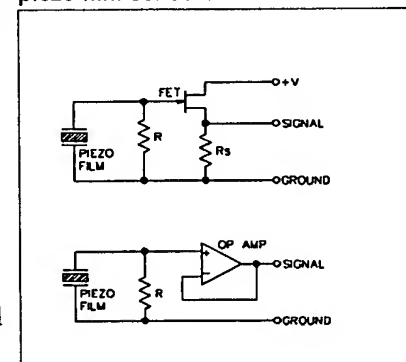


Figure 40. Unity gain buffer for piezo film sensors



amplifier is determined by Q/C_f . Q is the charge developed on the piezo film and C_f is the feedback capacitance of the charge amplifier.

The output voltage of the charge amplifier depends on the feedback capacitance, not the input capacitance. This indicates that the output voltage of a charge amplifier is independent of the cable capacitance. The major advantage of a charge amplifier can be realized when a long cable is used between a piezo film sensor and electronics. In addition, it also minimizes charge leakage through the stray capacitance around the sensor. Otherwise, simple voltage amplifiers are sufficient for most applications. Included in Figure 41 is a typical non-inverting voltage amplifier.

The advantage of a voltage amplifier can be seen when ambient temperature is considered. The voltage sensitivity (g-constant) variation over temperature is smaller than the charge sensitivity (d-constant) variation. Consequently, voltage amplifiers with piezo film exhibit less temperature dependence. In Figure 41, the time constants for the charge amplifier and voltage amplifier are determined by RC_f and RC respectively.

As a design example, a traffic sensor interface is described. Because of its flexibility, piezo cable is an ideal sensor material for traffic measurement applications. MSI's BL traffic sensor is constructed with a piezo cable sheathed in a compressed brass tube, with a variety of signal cable lengths tailored to the installation requirements. The BL is available in sensing lengths of more than 3 meters. In this specific example, the BL sensor is 2 meters long. This electrically shielded sensor has 100 feet of coax cable. The electrical specifications of this sensor include:

Capacitance = 9.5 nF (including piezo cable and signal cable capacitances)
 Output = 500mV (for a wheel load of 800 pounds at 55mph and 70°F)
 Signal : Noise = 10:1

The basic requirements of an interface circuit are:

Low end frequency = 1.6 Hz
 Circuit output = Digital pulse count

An interface circuit to meet these requirements is shown in Figure 42. This circuit works as a comparator. A $10M\Omega$ input resistance is chosen in order to reduce the cut-off frequency to about 1 Hz. The actual cut-off frequency with this resistor can be calculated as 1.6 Hz. A $10M\Omega$ potentiometer is used to adjust the threshold voltage, V and the diode is included to protect the electronics from high voltage signals damage. Typical piezo film and interface circuit output signals from a passenger car at 55 mph are shown in Figure 42.

Figure 41. Typical amplifiers for piezo film sensors

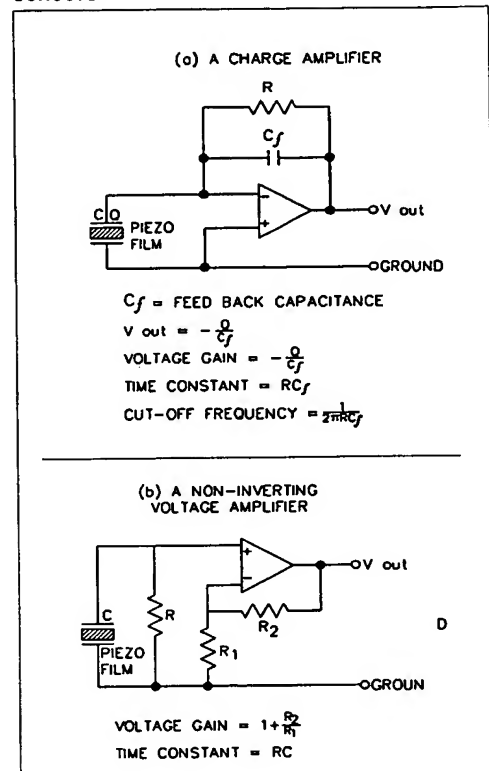
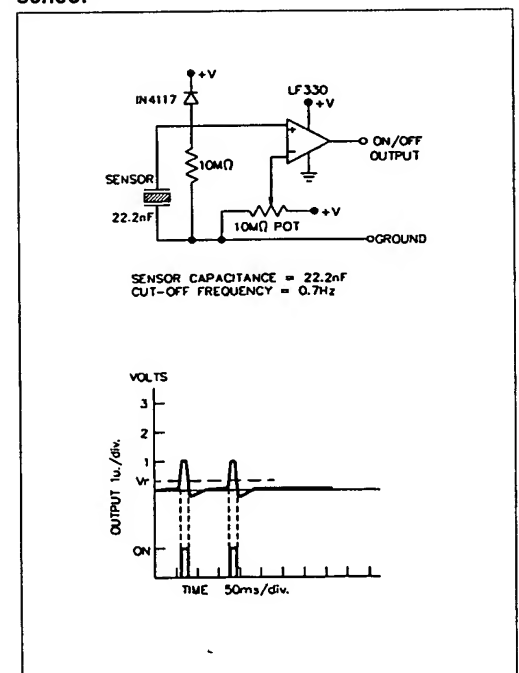


Figure 42. An interface circuit of a traffic sensor



Signal Conditioning

Because piezo film is both piezoelectric and pyroelectric, some provision must be made to eliminate—or at least reduce—the effect of unwanted signals. The primary principles of signal conditioning include:

- **Filtering**—Electrical filters designed to give the desired band-pass and band-rejection characteristics.
- **Averaging**—If the desired signal exhibits periodicity, while the undesired signal is random, signal averaging can increase the signal-to-noise ratio.
- **Common Mode Rejection**—By wiring two equal areas of a piezo film electrode out-of-phase, unwanted common-mode signals can be made to cancel.

Basic Switch Circuitry

A variety of circuits are available to electronically interface with piezo film including field effect transistors (FETs), operational amplifiers (Op Amps), and low-current digital logic (CMOS).

FETs lend themselves to applications of small size since they are readily available in surface mount technology. Important characteristics to consider when using FETs are switching frequency, piezo film capacitance, leakage current of the FET in the off-state, input bias resistance, and shielding from electromagnetic interference (EMI).

Figures 43 and 44 show typical FET circuit configurations for a piezo film switch. Figure 43, the common drain or source follower, applies well in applications where simple buffering is important. Here, the circuit voltage gain is approximately one.

The common source circuit in Figure 44 is suitable for low frequency applications where voltage gain is required. The gain is determined by resistances R_D and R_S . As the gain increases, frequency bandwidth decreases by a factor of one decade per 20 dB of gain.

Operational amplifiers offer a great deal of versatility for piezo film switch applications. Adaptation to a particular application is often as simple as making a few wiring changes. Important op amp circuit characteristics include input bias resistance, film switch capacitance, and EMI shielding.

The op amp circuit of Figure 45, a charge amplifier, suits applications where a detected vibration actuates the switch. It also works well in small signal applications. A charge amplifier eliminates the effects of the time constants of both the piezo film and connecting cable. The charge amplifier is a current operated circuit with zero input impedance, which results in no voltage being generated across the film. The charge amplifier quickly absorbs charges developed by the film. With no charge left on its electrodes, the film exhibits no time constant.

The capacitance of the film and connecting cable have no adverse effect on the circuit's transfer function. Thus tolerances on film size and cable length need not be exceptionally tight. The charge is

Figure 43. High frequency, low gain FET circuit interface

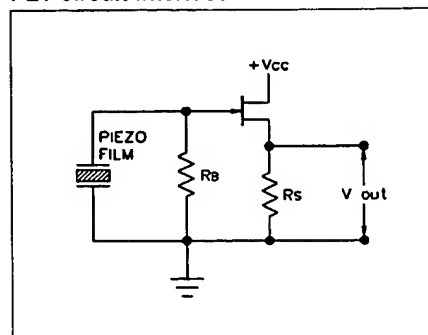


Figure 44. Low frequency, high gain FET circuit interface

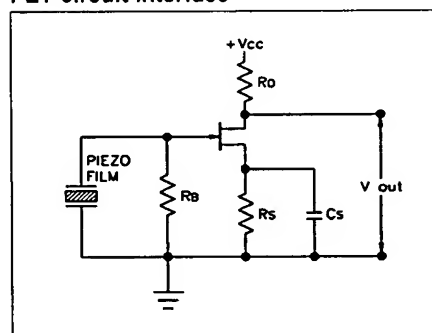
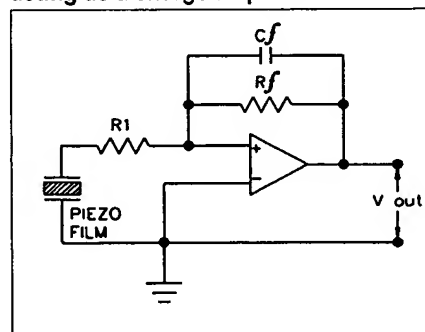


Figure 45. Op Amp Interface circuit acting as a charge amplifier

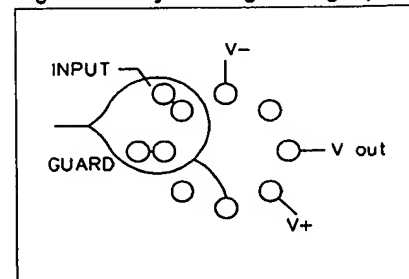


transferred from the film to the capacitor in the amplifier's feedback loop, which determines the output voltage: $V = Q/C_f$.

The charge amplifier requires an op amp having a high input resistance and low bias current. A high input resistance avoids bleed-off of the charge on the feedback capacitor, and low bias current prevents the feedback capacitor from charging and discharging at excessive rates. The layout of the charge amplifier circuit is critical. The op-amp casing must be well grounded and the inputs should be guarded and connected to the same ground as the casing.

A layout with guarded inputs is shown in Figure 46. Also, to prevent leakage noise from being amplified by the op-amp, the input cable should be terminated using a well-insulated stand-off connector.

Figure 46. Layout for guarding inputs



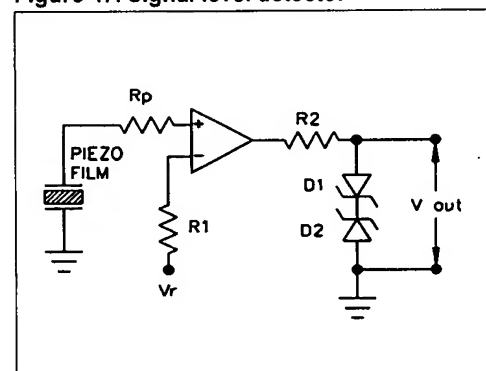
Even with the above precautions, it is likely that the output voltage will drift. To compensate for drift, a reset switch is generally designed into the circuit to manually reset the output to zero at intervals. One technique is to place a reed switch in series with a resistor, which is in parallel with the feedback capacitor C_f . Activating the reed switch closes the switch, discharging the voltage stored in the feedback capacitor.

Another method is to use a MOSFET device in which the maximum output voltage and off-gate voltage determine the minimum gate voltage of the FET. In practice, a supply voltage greater than the amplifier voltage is applied to the gate of the MOSFET, thereby lowering its drain/source resistance and creating a current path for discharge of the feedback capacitor.

The third alternative is to place a bleed resistor across the feedback. This resistor creates a time constant ($C_f R_d$), which is independent of the film capacitance and can be accurately controlled.

The signal level detector of Figure 47 fits applications where large signal-to-noise ratios are desirable. This circuit is perfect for detecting an impact among low-level vibrations. For situations where signal to noise ratios are low and where impacts or pressures must be discerned from background vibration, the differential amplifier circuit of Figure 48 is appropriate. This circuit consists of two sensors driving a differential amplifier.

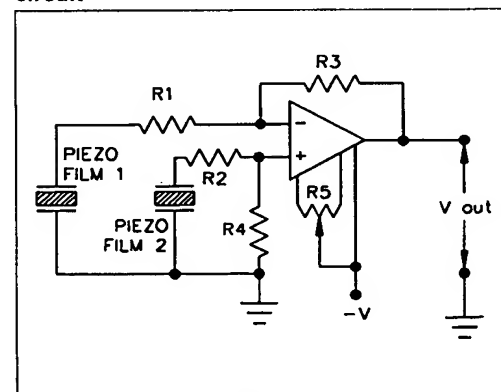
Figure 47. Signal level detector



This configuration uses a common-mode rejection concept. The two switches are mechanically coupled to cancel unwanted vibrations that stimulate both. An input or pressure on one switch but not the other, will produce an output.

CMOS logic offers a low-cost way to interface with piezo film. As mentioned earlier, low-power circuits implemented with CMOS technology are ideally suited to piezo film switches. CMOS applications for piezo film are generally for low frequency operation. Other characteristics to consider include device input leakage current and input impedance,

Figure 48. Differential Op Amp interface circuit



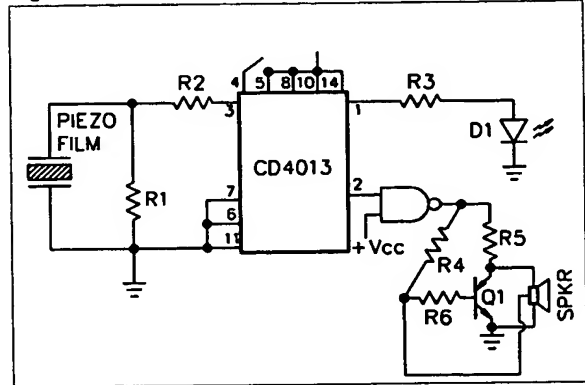
input bias resistance, and the effect of EMI. A CMOS circuit can be used, for example, in applications to sense a single impact or a single pressure.

The D-Flip Flop in Figure 49 indicates the presence of either the impact or pressure to set off an audible alarm.

The circuit in Figure 50, senses multiple impacts or pressures for counting applications.

Many different CMOS circuit configurations are possible to interface with piezo film. Common to all of them is an input bias resistor in parallel with the piezo film, and an input resistor in series with the film. The bias resistor handles leakage current and the series resistor limits current to protect against electrostatic discharge.

Figure 49. CMOS circuit for detecting a single impact

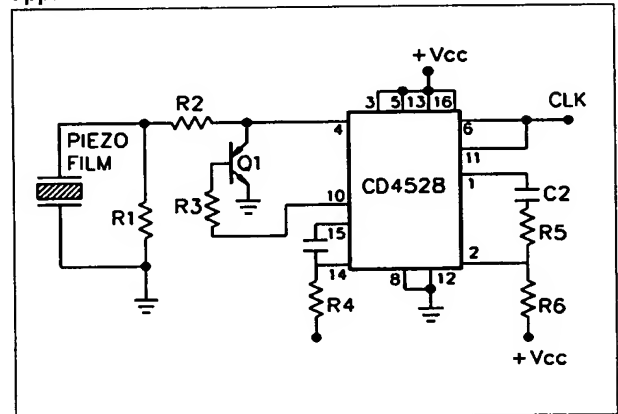


Cables

In applications where it is not possible to place the amplification circuit in close proximity to the piezo film transducer, considerable care must be exercised in selecting the connecting cable that carries the high-impedance signal.

Shielded coaxial cable, while used for noise reduction, can add problems associated with cable leakage and added capacitance. In most cases the cable's primary insulation should consist of highly resistant, non-polar plastics such as high-purity polyethylene or Teflon® (PTFE). It is equally important to make the cable as vibration-free as possible since cable movements generate noise that interferes with signal transmission.

Figure 50. CMOS interface circuit for counting applications



MANUFACTURING

Rolls of piezo film are produced in a clean room environment. The process begins with the melt extrusion of PVDF resin pellets into sheet form, followed by a stretching step that reduces the sheet to about one-fifth its extruded thickness. Stretching at temperatures well below the melting point of the polymer causes chain packing of the molecules into parallel crystal planes, called "beta phase". To obtain high levels of piezoelectric activity, the beta phase polymer is then exposed to very high electric fields to align the crystallites relative to the poling field. Copolymers of PVDF are polarizable without stretching.

Evaporatively deposited metals are typically 500 to 1000 Å in thickness, and almost any metal can be deposited. Popular metals are nickel, aluminum, copper, gold and alloys. Electrode patterns are made by sputtering through masks or by chemical etching continuous metallizations using photoresists. Resolution to 25µm line widths has been achieved. Screen printed electrodes of conductive silver ink are much thicker, about 5-10 µm, and can be applied in complex patterns to form multiple sensors on a single sheet. Foils are adhered with thin adhesive layers and capacitively coupled to the piezo film. Each electrode alternative has advantages and disadvantages.

Generally, sputtered metals are for very high resolution arrays, pyroelectric applications requiring a low thermal mass, or for inertness, as with invasive medical applications. Fully metallized sheets can be carefully cut with a razor blade without shorting across the film thickness. Screened inks are very robust and compliant, withstand very high strains (>10%), can operate at high voltages without breakdown, and are easy to pattern on a continuous basis. However, unmetallized borders are required for cutting elements out of a sheet of screen printed electrodes, since there is a high likelihood of shorting across the film thickness with the thick inks. Foils may mechanically restrict the piezo film from responding to externally applied stresses and strains in the plane of the film, but foils are useful in pure "thickness mode" operation.

After metallization, a wide variety of possible processing steps are followed to produce a packaged sensor. Generally, the piezo film is laminated in a protective carrier film, die cut to size, and packaged with lead wires or crimp connectors and, often, signal conditioning electronics. The wide range of packaged sensors, from a few square millimeters (including an ASIC chip) as a shipping damage sensor, to multiple square meter sensors for sports scoring targets suggests the versatility of this technology.

APPLICATIONS

The sensor applications described below represent a good cross-section of the products now using piezo film sensors.

Switches

The reliability of contact switches is reduced due to contaminants like moisture and dust which foul the contact points. Piezo film offers exceptional reliability as it is a monolithic structure, not susceptible to this and other conventional switch failure modes. One of the most challenging of all switch applications is found in pinball machines.

A pinball machine manufacturer uses a piezo film switch manufactured by MSI as a replacement for the momentary rollover type switch. The switch is constructed from a laminated piezo film on a spring steel beam, mounted as a cantilever to the end of a circuit board.

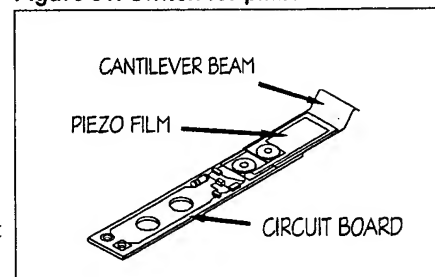
The "digital" piezo film switch features a simple MOSFET circuit that consumes no power during the normally-open state. In response to a direct contact force, the piezo film beam momentarily triggers the MOSFET. This provides a momentary "closure" for up to a 50 V maximum voltage. The output of this low profile contactless switch is well suited to logic-level switching. The unit does not exhibit the corrosion, pitting or bounce that are normally associated with contact switches.

The company has tested these switches in excess of 10 million cycles without failure. The switch solves the nagging problem of fouled contacts in pinball machines, a significant source for machine downtime and lost revenue. The simplicity of the design makes it effective in applications which include:

- ! Counter switches for assembly lines and shaft rotation
- ! Switches for automated processes
- ! Impact detection for machine dispensed products
- ! Panel switches
- ! Foot pedal switches
- ! Door closure switches

The cantilever beam that carries the piezo film can be modified to adjust switch sensitivity for high to low impact forces. Figure 51 shows the construction of the digital switch.

Figure 51. Switch for pinball machine

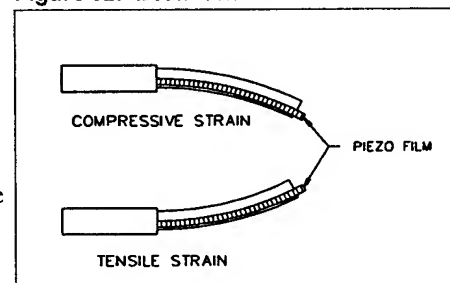


Beam Switch

Piezo film switches can be used to measure the amplitude, frequency and direction of an event and are useful in object detection and recognition, counting, wakeup switches and bidirectional encoding applications. The construction of the beam-type switch is shown in Figure 52.

Note that the piezo film element is laminated to a thicker substrate on one side, and has a much thinner laminate on the other. This moves the neutral axis of the structure out of the piezo film element, resulting in a fully tensile strain in the piezo film when deflected downward, and a fully compressive strain when deflected in the opposite direction. Were the neutral axis in the center of the piezo film element, as would be the case if the two laminae were of equal thickness, the top half of the piezo film would be oppositely strained from the bottom half under any deflection condition, and the resulting signals would therefore be canceled.

Figure 52. Beam switch



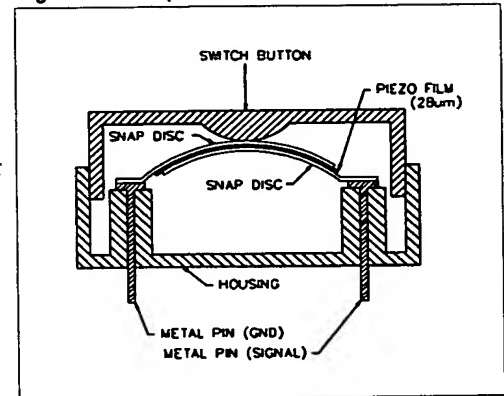
Beam switches are used in shaft rotation counters in natural gas meters and as gear tooth counters in electric utility metering. The beam switch does not require an external power source, so the gas meter is safe from spark hazard. Other examples of applications for the beam switch include a baseball target that detects ball impact, a basketball game where a hoop mounted piezo film sensor counts good baskets, switches inside of an interactive soft doll to detect a kiss to the cheek or a tickle (and the sensor is sewn into the fabric of the doll), coin sensors for vending and slot machines and as digital potentiometer for high reliability.

Snap-Action Switches

Piezoelectric materials do not have a true dc response. Very slow events, 0.0001 Hz, for example, are not normally possible to detect with piezoelectric film.

In switch applications where dc response is required, piezo film in combination with a snap dome provides a high voltage pulse.

When the snap device actuates, the film is rapidly strained, typically generating a 10 volt pulse into a one megohm circuit as shown in Figure 53. This concept is especially well suited for wakeup switches, where an electronic device can be dormant for long periods without power consumption until the snap action device is actuated. The piezoelectric pulse turns on the electronics. Battery operated parking meters, where battery life is very critical, are an example of a piezo snap action switch application. A thermal snap action device also employs this principle.



Impact Sensors

Impact Printers

High speed impact printers require very accurate print head timing. Impact must occur the instant that a high speed revolving steel band, embossed with print characters, is properly positioned in front of the print hammer. Any advance or delay in energizing the print hammer will result in an offset print of the desired character.

Piezo film sensor strips, built into the printer platen, monitor the impact timing and force of the bank of print heads, and transmit the information to the controller. Automatic adjustment is made in the actuator timing to accommodate any minor change in print head timing. The very high speed of the embossed steel ribbon, about 300 inches per second, requires a very fast switch response. Alternative impact switches are quickly destroyed by the large impact forces of the print head. Piezo film switches have been in use in this application for more than five years without failure.

Sports Scoring

Piezo film sensors can be used to measure impact time, location (accuracy) and force. These parameters are desirable in several sports scoring applications. The energy of a 90 mph pitch has instantaneous power of about 50,000 watts! The great challenge in this application is target ruggedness without the introduction of severe bounceback into the design.

A second sports scoring application is electronic dartboards, where piezo film monitors the many impact zones in the game. Scoring is electronically recorded.

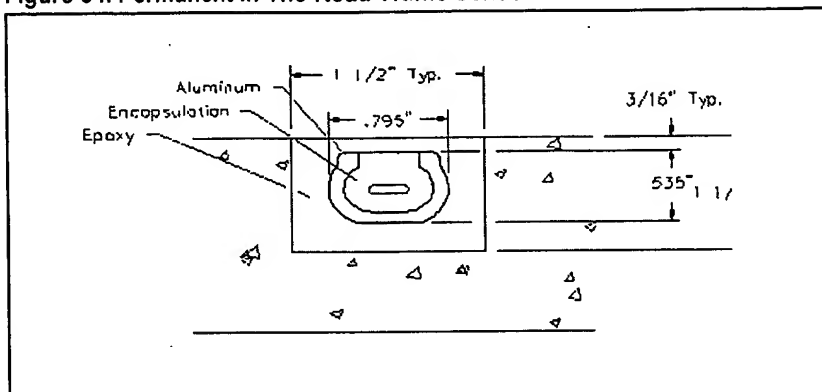
Musical Instruments

The popularity of electronics for musical instruments presents a special problem in drums and pianos. The very high dynamic range and frequency response requirements for drum triggers and piano keyboards are met by piezo film impact elements. Laminates of piezo film are incorporated in foot pedal switches for bass drums, and triggers for snares and tom-toms. Piezo film impact switches are force sensitive, faithfully duplicating the effort of the drummer or pianist. In electronic pianos, the piezo film switches respond with a dynamic range and time constant that is remarkably similar to a piano key stroke.

Traffic Sensors

The U.S. Government is actively studying "smart highways" as an alternative to major new highway construction. The idea is that existing highways can accommodate greater vehicle densities if electronically managed. In addition to conventional traffic monitoring for highway studies and enforcement, the Intelligent Vehicle/Highway System (IVHS) programs create the need for new classes of "smart highway" high speed sensors to count and classify vehicles, provide lane control, and to monitor weight and speed. IVHS also requires "smart car" sensors, and advanced vehicle surveillance, communications, and software.

Figure 54. Permanent In-The-Road Traffic Sensor

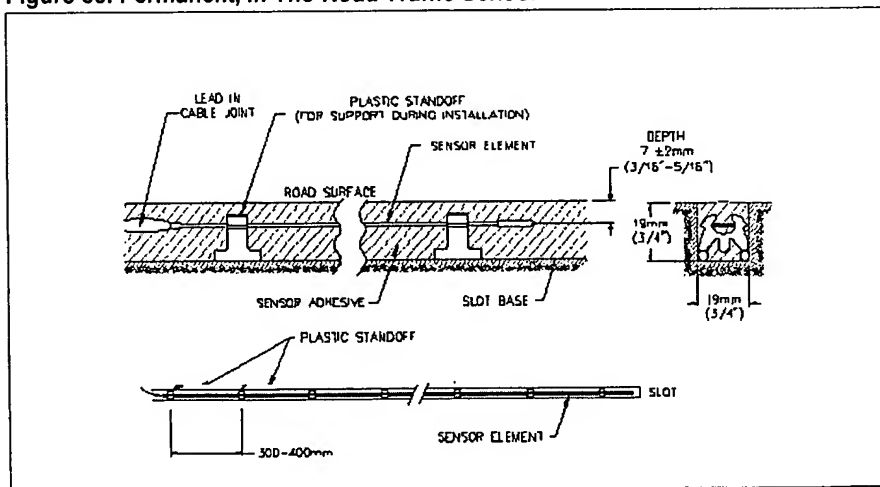


Futuristic programs like the IVHS, and more contemporary projects like the Strategic Highway Research Program (SHRP), require traffic data collection to provide the necessary information required by the Federal Highway Administration on highway structures. Recent advancements in signal processing open the door to greatly improved real-time vehicle data analysis, provided that inexpensive reliable sensor technologies are developed.

Pneumatic road tubing has long been the workhorse of traffic data collection. Road tubes provide a pneumatic pulse to a piezoelectric membrane, which triggers nearby electronics when an axle is detected.

The evaluation of alternative sensor technologies has shown piezo cable provides the necessary sensitivity, linearity, noise immunity and environmental stability for high traffic interstate vehicle classification and weight-in-motion systems. Piezo cable BL sensors are used for traffic data collection from Saskatchewan to Florida.

Figure 55. Permanent, In-The-Road Traffic Sensor

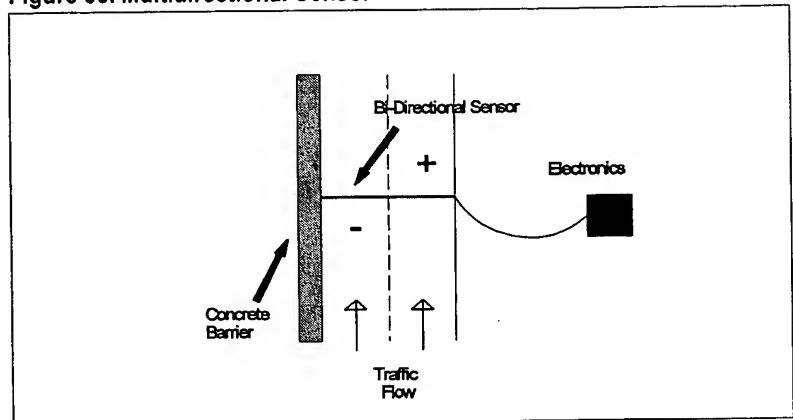


Piezo cable traffic sensor constructions are shown in Figures 54 and 55. There are two basic categories of traffic sensor ... permanent and temporary. Generally,

permanent sensors are mounted in the road with the top of the sensor flush to the highway surface, while temporary units are adhesively applied to the road surface for shorter monitoring periods. Permanent sensors, used for toll booths and interstate highway data collection, are flush mounted to a road surface and must withstand the rigors of years of high density traffic, snow plows, salt, sand, water and dragging mufflers.

"New Jersey barriers", the modern concrete barriers that separate opposing lanes on highways, introduce problems for multilane sensing of four lane highways. Piezo cable can solve this problem with a single sensor that has opposite polarities corresponding to each lane. Vehicles crossing the near lane produce a signal of opposite sign from vehicles in the far lane (Figure 56). This ability to provide lane activity in a single sensor is a significant development.

Figure 56. Multidirectional Sensor



Traffic sensors can monitor vehicle speed, count axles, weigh vehicles, provide direction, and vehicle classification. Recently, these sensors have also proven valuable on airport taxiways. From the output, one can discern the ground speed of an aircraft (time lag between two sensors), its direction, weight (fueled), number of axles, and the span of the aircraft (determined from the speed and the known fixed distance between sensors). This information can be used to classify the aircraft and provides taxiway traffic control and safety information at airports.

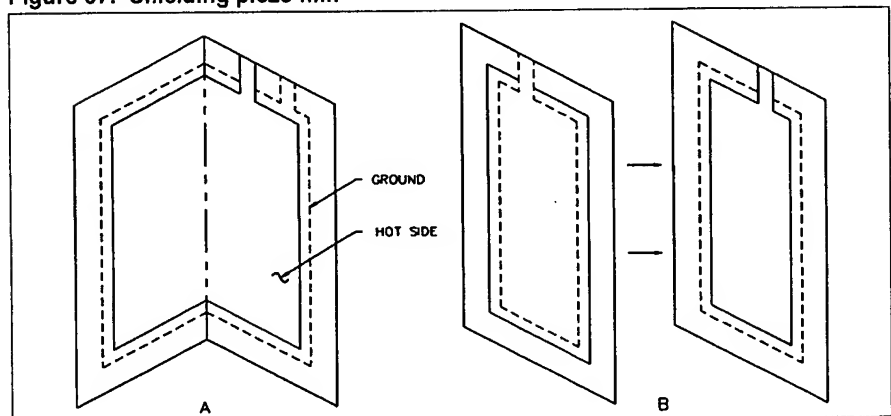
VIBRATION SENSING

One of the first applications for piezo film was as an acoustic pickup for a violin. Later, piezo film was introduced for a line of acoustic guitars as a saddle-mounted bridge pickup, mounted in the bridge. The very high fidelity of the pickup led the way to a family of vibration sensing and accelerometer applications.

Music Pickups

Piezo film is used today in several guitar pickup designs; one is a thick film, compressive (under the saddle) design; another is a low cost accelerometer, while another is an after market pickup design that is taped to the instrument. Because of the low Q of the material, these transducers do not have the self-resonance of hard ceramic pickups. Shielding can be achieved by a foldover design as shown in Figure 57. The hot side is the slightly narrower electrode on the inside of the fold. The foldover technique provides a more sensitive pickup than alternative shielding methods because the shield is formed by piezoelectric material. Conventional shielding laminates can be easily fabricated by a multilayer laminate of piezo film, adhesive and shielding foil.

Figure 57. Shielding piezo film



Machine Monitoring

The fidelity of a shielded piezo film sensor in musical instruments led to the development of vibration sensors for machines. In its simplest mode, piezo film vibration sensors behave essentially like dynamic strain gages. The film does not require an external power source, yet typically generates signals greater than strain gages **after** amplification. A typical piezo film sensor produces four orders of magnitude higher voltage signal than a foil-type strain gage, and two orders higher than semiconductor types. The frequency response of the piezo film strain gage is also superior.

The extreme sensitivity is due to the form of the piezo film material. The low thickness of the film results in a very small cross sectional area. Thus very small longitudinal forces create very large stresses within the material.

Piezo film sensors can be affixed to a vibrating surface and monitor the amplitude and frequency of the vibrating structure. The sensors can cover larger areas than normal strain gages so any direct comparisons should be performed in **uniform** strain fields for meaningful results. Obviously, point-type transducers may be used where required, although the low capacitance of the small sensor area will require additional consideration. Operation down to fractions of Hz can be achieved by either conventional charge amplifiers or, since signal levels are relatively high, simple high impedance FET buffer circuits.

Bearing Wear Sensors

A shielded piezo film sensor has been used to monitor bearings for wear and evidence of spall. The sensors are permanently affixed to the outer surface of the bearing race with epoxy. The low mass and thin profile allow its use as a built-in nondestructive testing sensor, rather than the time consuming use of accelerometers for periodic fault-condition checks.

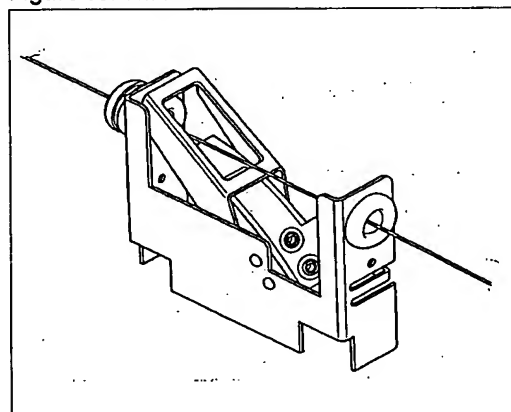
Fan Flow Sensor

A laminated beam type sensor is used in ducted airflow as a centrifugal fan failure sensor. The presence of air flow is detected by the vibrations in the sensor caused by the turbulence of air flow at about 100 Hz. The absence of this signal is used for trigger electronics. The sensor and switching electronics are based around a TL084 quad bi-FET op amp, with typical input signals of 80 mV. Sensor reliability is the key feature. Since the sensor is subjected to virtually no operating stresses, it has an indefinite working life.

Thread Break Sensor

Textile plants require the continuous monitoring of often thousands of lines of thread for breakage. An undetected break event can require that a large volume of material be discarded, as the labor costs to recover the material exceed the manufacturing cost. Drop switches, where switch contact closure occurs when the thread breaks, are very unreliable. Lint fouls the contact points, resulting in no output signal. A piezoelectric film vibration sensor, mounted to a thin steel beam, monitors the acoustic signal caused by the abrasion of the thread running across the beam, analogous to a violin string (Figure 58). The absence of the vibration instantly triggers the machinery to stop. Thread tension and defects in man-made fibers are also monitored with piezo film textile sensors.

Figure 58. Threadbreak sensor



Vending Sensors

Shielded dynamic strain gages of piezo film are affixed to the underside of a vending product delivery tray to verify that product was properly vended. The absence of the impact induced vibration triggers an "Out of Order" warning. In a second application, slot machine coin counting is provided by a piezo film element. The sensors confirm delivery of coins won, discouraging gamblers from falsely claiming equipment defects. A ticket dispensing machine counts tickets delivered with a piezo beam design. Coin sensors also trigger or wake-up vending machines and coin changer electronics to verify coin authenticity.

ACCELEROMETERS

A logical outgrowth of the many vibration sensor applications of MSI's piezoelectric technology are accelerometers. These accelerometer designs are based on more traditional piezoelectric ceramic, as well as piezoelectric polymer materials. The choice of base materials allows the product to be tailored for specific applications. Table 6 lists the key specifications for the MSI Accelerometer product family.

Like more conventional sensors, these accelerometers are configured as either compression-design type or beam-design type. Compression-design accelerometers typically have higher resonant frequencies providing wide useful frequency ranges. An internal view of MSI's ACH-01-XX compression-design accelerometer is shown in Figure 59.

Beam-design accelerometers tend to have lower resonant frequencies and useful frequency ranges. Beam-design accelerometers also have another very interesting feature: They can be oriented to sense acceleration in multiple-axes with one monolithic sensing element using MSI's patented "Origami" beam technology ("Origami" is the Japanese word for the art of paper folding). An internal view of the ACH-04-08-05 three axis beam-design accelerometer, with its origami sensing element, is shown in Figure 60.

To reduce system costs as well as simplify use, all of MSI's accelerometers include buffers. JFET biasing and signal processing is implemented external to the device.

The ACH-01 family of products is typically used in applications which require broad frequency capability, high sensitivity, low noise, and low cost. Such applications include: speaker feedback and control systems, automotive anti-theft systems, acoustic pick-ups, machine-health and pump and centrifuge monitoring systems, and medical body motion monitoring.

The ACH-04-08 product family is used in a very broad range of applications such as speaker feedback and control systems, appliance fault monitoring, virtual reality systems, automotive systems, medical body motion monitoring, shipment damage and material-handling monitoring systems, vibration switches and earthquake shut-off switches. OEM applications that require acceleration or vibration measurements in more than one axis are perfect for the ACH-04-08-05.

MSI is constantly developing and upgrading its accelerometer product line. Please contact MSI for further details on these products or on customizing one of our other products.

Figure 59. ACH-01-XX internal view

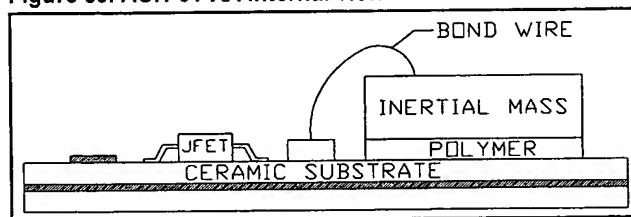


Figure 60. ACH-04-08-05 internal view

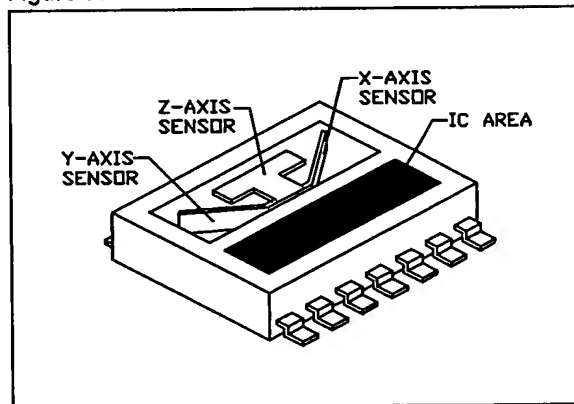


Table 6. Accelerometer Family

Production Qualified Accelerometers				
		ACH-01-XX	ACH-04-08-05	ACH-04-08-09
Key Features		-Wide Frequency Range -Wide Dynamic Range -High Sensitivity -Low Noise -JFET Buffer	-Low Frequency Operation -3 Simultaneous Analog Outputs -Low current generation -JFET Buffer	-Low Frequency Operation -Low Current Operation -JFET Buffer
Sensitive Axes	X-Axis	---	X	--
	Y-Axis	---	X	X
	Z-Axis	X	X	--
Sensitivity (Nominal)		10 mV/g	1.8 mV/g	6mV/g
Frequency Range (± 3 dB)		1.0 Hz-20 kHz	0.5 Hz to 4 kHz	0.2 to 1500 Hz
Dynamic Range		± 250 g	± 250 g	± 40 g
Resolution (@ 100 Hz)		$40\mu\text{g}/\sqrt{\text{Hz}}$	$200\mu\text{g}/\sqrt{\text{Hz}}$	$40\mu\text{g}/\sqrt{\text{Hz}}$
Resonant Frequency		>35 kHz	9.2 kHz	3.4 kHz
Resonant Q (Hz/Hz)		30	10	10
Transverse Sensitivity		5%	15%	<20%
Linearity		0.1%	0.1%	0.1%
Operating Temperature		-40 °C to +85 °C	-40 °C to +85 °C	-40 °C to +85 °C
Storage Temperature		-40 °C to +85 °C	-40 °C to +85 °C	-40 °C to +85 °C
Maximum Shock		1000 g	1000 g	1000 g
Supply Voltage		3 V to 40 V	3 V to 40 V	3 V to 28 V
Supply Current		2 μ A Typical	6 μ A Typical	2 μ A Typical
Weight		3 grams	0.35 grams	0.35 grams
Size (mm)		13 x 19 x 6	11 x 10 x 1.8	11 x 10 x 1.8
Mounting Method		Adhesive	Hand Solder to PCB	Hand Solder to PCB

Table 7. Accelerometer Applications

Industry	ACCELEROMETER PRODUCTS			
	Application	ACH-01-XX	ACH-04-08-05	ACH-04-08-09
<i>Aerospace & Defense Electronics</i>	Anti-Tamper Sensors	X	X	X
	Surveillance	X		
	Modal Analysis	X	X	
<i>Automotive</i>	Antitheft	X	X	X
	Skid/Rain Sensing	X		
<i>Computers & Peripherals</i>	Computer Mouse Sensor		X	
	Virtual Reality Sensor		X	
<i>Household Appliances</i>	Out-of-Balance Sensor	X	X	X
	Spray Arm Jam Sensor		X	X
	μ wave Acoustic Sensor	X		
<i>Consumer Electronics</i>	Speaker Feedback	X		
	Acoustic Pick-ups	X		
	Security		X	X
<i>Industrial</i>	Machine Health Monitor	X	X	
	Bearing Monitor	X	X	
<i>Instruments & Measuring Equipment</i>	Active Vibration Damping	X	X	X
	Predictive Maintenance	X	X	X
<i>Medical</i>	Motion Sensor	X	X	
	Pacemaker	Consult Factory for further Information		
<i>Power & Utilities</i>	Earthquake Shut-Off		X	X
	Machine Monitoring	X	X	
<i>Transport & Material Handling</i>	Shipment Monitoring	X	X	
	Railroad Systems	X	X	X

ULTRASOUND APPLICATIONS

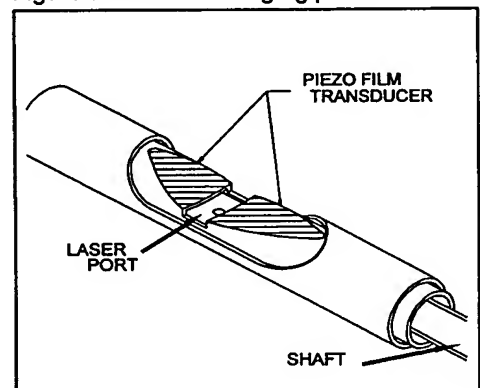
The wide frequency response and physical attributes of its polymeric construction makes piezo film a material of choice in certain medical probes and in nondestructive testing applications. Additionally, the film sensors are found in applications in ultrasonic based sensing devices, like air-ranging ultrasound for distance measurement, in fluid level sensors, and in-flow measurement instruments using doppler shift of sound velocity perturbations which are proportional to fluid flow.

Medical Imaging Ultrasound

Piezoelectric ceramic materials are used in medical imaging transducers because of their high sensitivity and broad bandwidth. The d_{33} constant, strain developed for an applied voltage, is about an order of magnitude higher for piezo ceramics than for piezo polymer. A disadvantage of piezo ceramic is its high acoustic impedance, about 30 MRayls ($1 \text{ MRayl} = 10^6 \text{ kg/m}^2\text{s}$) in contrast to about 1.5 MRayls for body tissue. This impedance mismatch can be compensated by quarter wavelength matching layers, but these can degrade the ultrasonic pulse due to adhesive layers and construction methods. The acoustic impedance of piezo film is about 4 MRayls, a much better match. Additionally, in higher frequency applications requiring very thin piezo elements, ceramics are too fragile, and cannot be shaped to desired geometries.

Invasive imaging requires lower powered devices than external probes. Resolution of the image is considerably improved at the higher frequencies of invasive catheters. A medical imaging company has developed an invasive imaging probe with piezo film for a therapeutic laser prostate catheter (Figure 61). The piezo film sensor is about 30 microns thick, and is located near the catheter tip. The unit operates at frequencies of 7 MHz and higher.

Figure 61. Invasive imaging probe



Steered *in-vivo* phased-array images using piezo polymer film have been produced for the first time by researchers at Duke University. A 32 element array of $11 \text{ mm} \times .56 \text{ mm}$ elements was fabricated and tested with a well matched circuit designed to optimize the transducer. The result was 28 dB lower sensitivity than PZT transducers at 2.5 MHz operating frequency.

However, the piezo film array had improved axial resolution, better angular response (6 dB pulse-echo response at 30 degrees), and a low interelement cross-coupling of -35 dB. It is exceptionally difficult to diamond blade saw PZT ceramic into these small elements; while, for piezo film, complex patterns are readily etched into the surface gold electrode. PZT must be diced due to the severe interelement coupling problem. Duke University researchers plan to improve the polymer probe by expanding the number of array elements to 128.

Very high resolution arrays have been traditionally formed by etching an electrode pattern on the surface of a piezo film. Newer techniques include deposition of the copolymer directly onto silicon wafers. The wafers are etched to minimize interelement coupling, then the copolymer is applied by spin-coating, followed by poling. Then a top ground electrode is applied and inter-connections made. This advance results in a very high resolution imaging. Capacitively coupling copolymer film to a dense array of conductive traces on a PCB has achieved remarkable performance as a Tx/Rx array.

NonDestructive Testing (NDT)

Advanced composite materials are very desirable as structural members. Light weight, high strength, corrosion resistance, and non-magnetic are among the advantages for these materials. The need for very routine nondestructive testing of such structures to prevent catastrophic failure due to delamination, is one of technology's greatest concerns. Flexible sheets of piezoelectric polymer transducer arrays, acoustically well matched to the composites, are desirable for use for non-destructive testing. One example is as an NDT array for testing rocket motor housings prior to launch. These arrays can be applied to the surfaces of composite fuel housings, and each element sequentially activated to provide a pulse-echo response. An array element size of about 0.5 to 1 square inch is sufficient for this application, as well as most large area NDT. Center frequencies of 3-10 MHz and -6 dB fractional bandwidths exceeding 100% are typical with such transducer arrays.

Systems and Instrumentation, Ltd. personnel use piezo film for NDT of aerospace engine parts. NDT transducers capable of detecting flaws down to 1/64th inch are now required. Further, the frequency response range of these new materials are broader than the bandwidth of conventional transducers. S&I, Ltd. find that a single broadband transducer covers the bandwidth of interest. Their transducers are also used in near-surface NDT applications, where high resolution and short pulse duration are required. Defects of 0.8 mm in size, lying within 1 mm of the surface, have been detected with the S&I probes.

Critical points or inaccessible test areas within a composite structure, like support strut mounts, where delamination or other damage is especially likely, can have custom fabricated NDT arrays permanently affixed for in-service testing and monitoring. It is possible to achieve uniformity of ± 1 dB between the elements of a multi-element transducer array. Special shaped transducers, providing special focal characteristics, have also been built with these polymer transducers.

Acoustic Emission

Acoustic emission of materials including fiber-reinforced composites, aluminum, steel and glass can be performed with contact microphones of piezo film, or, as with NDT, by large area arrays. These arrays can continuously monitor structures for 0.1 - 1.0 MHz acoustic emission, the precursor to structural failure. Piezo film, being broad band, responds well at these frequencies. This capability is especially necessary for critical application like tank rail cars carrying toxic products, underground fuel storage tanks, nuclear plants, etc.

Fluid Level Sensor

There are a variety of fluid level sensing transducer technologies available to the designer. A float arm, attached to a sliding potentiometric device is still widely used in automobiles. Ultrasonic pulse-echo devices that measure the distance from a fixed transducer to the fluid surface from above through air, or from below through the fluid, are popular. Newer capacitance types, where the fluid becomes the dielectric, are also used. Each of these technologies represent tradeoffs in system cost, performance and reliability. A new ultrasound level sensor, in development by MSI, holds promise as a digital, solid state ultrasonic level sensor.

The novel construction is a level sensor with ultrasonic through-transmission with multiple transmitters and a single, common receiver. The sensor is fabricated by attaching an unmetallized strip of piezo film to a printed circuit board containing electrode patterns, conductors, and interconnections to circuitry on the opposite side of the board. The electrode patterns are capacitively coupled to the piezo film layer, becoming the multiple transmitter elements. A second conductor bar, parallel to the patterned elements becomes the common receiver.

The presence of fluid couples the transmit signal to the receiver to a much greater extent (60dB) than when the ultrasound energy is coupled by the air above the fluid. The excitation signal for the transmitter is a 1.1 MHz sine wave tone burst with an amplitude of 20 volts peak to peak. The required circuitry consists of a high frequency oscillator and clock, an array of analog switches, a single receiver amplifier with input gate, and a threshold detector. These electronics can be reduced to the chip level, and are incorporated on the backside of the circuit board.

Resolution of the level sensor is determined by the resolution of the patterned transmit electrodes on the circuit board. Parallel elements of 2 mm width and 0.5 mm spacing between elements is a representative capability. The ground electrode for the transmitters is a fully gold metallized surface on the fluid side of the piezo film transmitter array. The receiver is formed by the same piece of piezo film, capacitively coupled to the signal electrode which is a separate conductor trace on the printed circuit board (PCB). Again, the ground is the backside electrode on the film.

The new level sensor has several unique advantages. The spacing between transmitter elements need not be uniform. For tanks that do not have a uniform volume throughout the tank height, a simple PCB layout can linearize the nonlinear tank volume by setting the transmitter element spacing accordingly. The output of the device is digital—no expensive A/D conversion is required. The level sensor is small in width, less than 1 inch, so it can be inserted into a small diameter tube. The tube confines the motion of the fluid, reducing large swings in fluid height readings caused by motion, as with an automobile fuel tank during cornering. Reliability is greatly improved. The level sensor is self diagnostic to the extent that the transmitter/receiver pair must be operational to deliver a meaningful signal. The absence of the signal indicates a fault condition. For a detailed discussion on Ultrasonic Ink Level Sensing, see Appendix C.

Air Ranging Ultrasound

Ultrasonic devices used in pulse-echo modes are used in robotics, vehicle safety and control system, object recognition systems and other remote distance measurement devices. The sensors provide high resolution in the targeted direction, and can be used to measure the elapsed time from transmit to receive to determine the distance to an object. Unlike piezo ceramic and electrostatic devices, piezo film can deliver a very short pulse (due to its low Q), allowing the same device to be used as both transmitter and receiver, even in the near field of the transducer.

Multiple piezo film elements can be easily fabricated, as shown in Figure 62. The geometries of these cylindrically shaped elements (length, radius of curvature, number of elements) can be designed to control the directivity pattern and acoustic properties. Transducers with operating frequencies from 40-200 KHz have been made. Average values of transducer sensitivity are 0.1-1 mV/Pa in the receive mode (noise was < 1 μ V) and 15-75 mPa/Vcm² in the transmit mode for 1 m of distance. The minimum distances measured in pulse-echo mode was 30 mm. Distances to 15 meters have been measured with a main beam width of less than 10 degrees, and maximum side lobe amplitudes that are 12 dB down at 60 KHz. Examples of directivity patterns for single and multiple element transducers are shown in Figure 63. Multiple

Figure 62. Air ranging ultrasound transducers

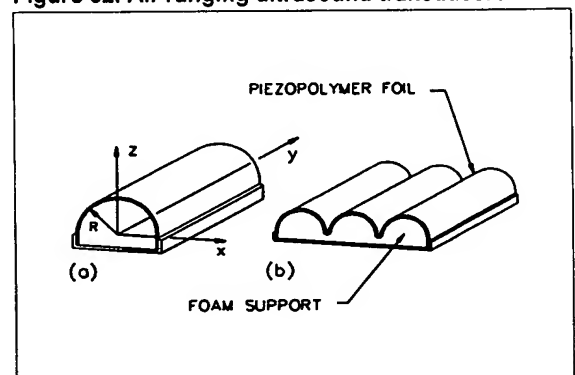
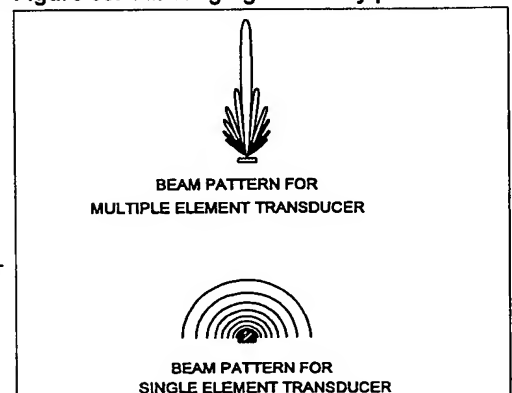


Figure 63. Air-ranging directivity patterns



elements can also be used for scanning of objects without physically moving the transducer. Each element within the transducer can be activated sequentially, as with ultrasonic arrays.

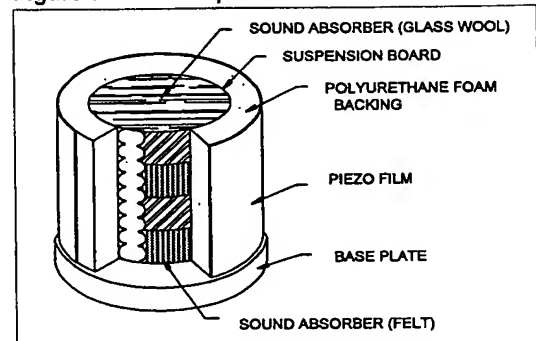
AUDIO

Speakers

One of the earliest applications for piezo film was in stereo tweeters (Figure 64) and headset speakers developed by Pioneer Electronics. There is strong renewed interest in these applications as a result of the improvements in the reliability of the electrodes and lead attachment and packaging techniques. Gallo Acoustics has developed a high fidelity omnidirectional tweeter using a cylinder of 52 μm thick piezo film. The tweeter rolls off at frequencies below 2 KHz, and features:

- 330 degrees of horizontal dispersion at high frequencies, which is as much as ten times the dispersion of conventional tweeters,
- very wide dynamic range,
- linear frequency response,
- very fast impulse response, faithfully reproducing the highest frequencies.

Figure 64. Audio speaker



Novelty audio speakers have also been developed. These devices make use of the thin, light weight, conformal nature of the piezo film. Examples include speakers for inflatables (like balloons and air inflatable toys), speakers in apparel (including headgear) and paper thin speakers for magazine advertising, greeting cards and posters.

Microphones

A diaphragm of piezo film, affixed in a retaining ring or mounted over a hole in a plate, makes an excellent microphone. Vacuum formed domes on a support can be introduced into the design to take the membrane slightly out of its neutral axis with a foam backing, a small post, bar or structure to give the film membrane a slight radius of curvature. A self-supporting, cylindrically curved film also achieves the mechanical bias. A typical radius of curvature for piezo film microphones which optimizes sensitivity and electroacoustic efficiency is $R_0 = 25 \text{ mm}$, similar to that of an electrostatic microphone construction.

Sennheiser reports a frequency response for a typical foam backed piezo film microphone of 25 mm diameter, having $R_0 = 25 \text{ mm}$. The free field sensitivity of the device measured at 1 KHz, for sound pressure incident on the membrane perpendicularly, was -58 dB re 1 V/Pa. Harmonic distortion approaches 1% only at sound pressure levels exceeding 122 dB, and are not significantly higher for the range of higher frequencies.

Microphones built with piezo film are low cost, but more importantly, are inherently immune to moisture, unlike electrostatic types.

Electrostatics dominate the market due to the low cost that has been achieved through very high volume manufacturing. Nonetheless, piezo film microphones are finding application in designs where

environmental stability is critical. Waterproof microphones are being supplied for divers, withstanding total immersion in salt water without damage.

SONAR

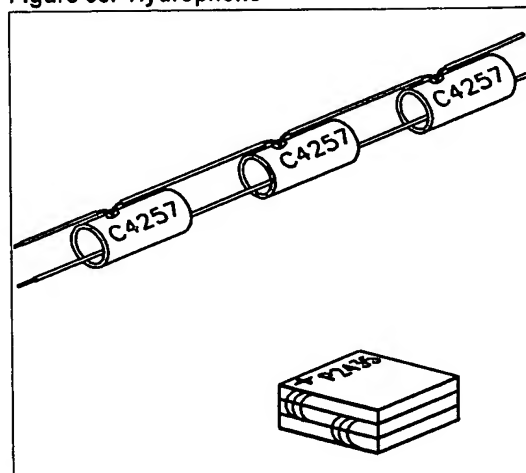
Piezo ceramic materials have been used in hydrophones for SONAR since the 1940's. Ceramics have many desirable features as hydrophones including high hydrostatic sensitivity, high capacitance, ability to fabricate into shapes, and availability in thick cross-section (sensitivity is proportional to piezo element thickness). However, the weight of ceramic is much greater than water, so buoyancy must often be added to structures as compensation.

The current trend in SONAR is toward higher numbers of hydrophone sensors per vehicle. Longer towed arrays and larger and more numerous hull mounted hydrophone panels are being employed by the fleet. This trend requires the advancement of much lower weight hydrophones making piezo film an excellent choice for these applications.

New piezo polymer hydrophones of thick film (1200 μm) have been made into sheet and cylinder form (Figure 65).

The cylinders, about 2-3 cm in length and <1 cm in diameter, are strung together into a continuous hydrophone line array. The hydrophones are very light weight (0.60 g/cm³), yet have excellent hydrostatic sensitivity.

Figure 65. Hydrophone



Piezo polymer hull mounted hydrophones in panels, of about one square meter in area and greater than 1000 μm in piezo polymer thickness, are used by the British and French Navies for submarines. Called "Flank Arrays", these units work in combination with towed arrays in advanced SONAR systems. Piezo film sheets are not fragile, conform to the radius of curvature of the hull, and are low cost. Typical sensitivities for the piezo film thick sheet hydrophones are similar to ceramic type (-192 to -195 dB re 1 V/ μPa). The lower capacitance of the piezo film hydrophones is compensated by the large area and number of parallel hydrophones used.

New hydrophone technologies, including underwater ultrasound imaging for divers and related applications are also in development.

FUTURE APPLICATIONS

Piezo film research is underway into an exciting new array of applications. A sampling of this R&D activity is highlighted below:

Active Vibration Damping

Piezo film sensor and actuator pairs are in development for active vibration damping. In this application, a piece of piezo film is employed as a strain gauge to detect vibration and another piece of piezo film is employed as an actuator to dampen the vibrational noise by applying a 180 degree phase-

shifted signal. Wide coverage of piezo film, with distributed electrode patterns, can be used to create individual sensor/actuator pairs. Critical damping has been achieved with this piezo film laminate by researchers at Massachusetts Institute of Technology and elsewhere.

The applications for this technology include the reduction in harmful vibrations in space-based structures, fuselage for aircraft to cancel engine noise, quiet cars, quiet appliances, and a wide range of other possibilities.

Sensors on Silicon

Piezoelectric polymers can be solution cast (spin coated) onto silicon, polarized in place, metallized in pattern arrays, and interconnected with the integrated circuits on the chip. Minor modifications to wafer processing make the silicon suitable for the piezo Polymer Sensor-On-Silicon (PSOS). Early work in PSOS technology at Stanford University was frustrated by the need to adhesively bond thin sheet piezo film onto silicon. The adhesive layer was difficult to apply to the silicon, introducing air bubbles, wrinkles, nonuniform thickness layers, etc. The advent of new piezo polymer processing that eliminates the adhesive makes the PSOS technology practical. R&D work at MSI and elsewhere includes the development of pyroelectric arrays for infrared cameras, fingerprint readers, and thermal imaging devices, ultrasound arrays for high resolution NDT and invasive medical imaging, and integrated accelerometers for microminiature components.

Smart Skin

Piezoelectric film can both sense surface energy and can microdeflect the surface. These capabilities may be of interest in active surfaces for sound cancellation, extension of laminar to turbulent flow boundaries, etc. Considerable work is under way at university and government laboratories in these and related applications.

Appendix A – Applications of Piezo Film

APPLICATIONS OF PIEZO FILM	
<u>COMPUTER INPUT/OUTPUT</u>	
<i>Keypad arrays</i> Digitizer Air Mouse Joystick Pen (Signature verification; Handwriting Recognition)	<i>Physical Security & Energy Management</i> Glass Break Detectors Floor/Mat Sensor Penetration Detection Contact Microphone Piezo Cable Perimeter Protection Pyrometer/Flame Sensor
<i>Printers</i> Impact Flight Time Ink Drop Generation and Detection Toner and Ink Jet Level Toner Activation	<i>Flow/Level</i> Vortex Fluidic Oscillator Air Flow Doppler Ultrasound Solid State Fluid Level Laminar/Turbulent Boundary Layer Fan Failure
<i>Business Equipment</i> Antitamper for ATM Machine Coin Counters Copiers Switches Paper Path Switches Toner Level and Activation	<u>INSTRUMENTATION</u>
<i>Disc Drives</i> Shock Sensing Accelerometers	<i>Machine Health Monitor</i> Accelerometers Contact Microphones Hi-Strain Dynamic Strain Gages
<u>INDUSTRIAL</u>	<i>Weather Sensors</i>
<i>Switches</i> Solid State Momentary Snap Action Cantilever Beam Keypad Vandal-Proof Intrinsically Safe CMOS Wake-up Low-Deflection Singing Switch (a.c. switch) Coin Counter Acoustic Switch Shaft Rotation Counter	Rain Intensity Hail Detection Wind Velocity
<i>Robotics</i> Tactile Sensor Micropositioner Safety Mats & Switches Bumper Impact	<i>Active Vibration Damping</i> Strain Gages Sensor Arrays Actuator Arrays
	<i>Non Destructive Engineering</i> Flexible Contact NDT Probes NDT Arrays Acoustic Emission Sensors
	<i>Air Ranging Ultrasound</i> Safety Distance
	<i>Adaptive Optics</i> Fiber Optic Shutters/Modulators Deformable Mirrors Laser Scanners
	<i>Oil Exploration</i> Hydrophones Seismic Geophones

MEDICAL

Diagnostics

- Apnea Monitor
- Ambulatory/Gait Monitors
- Blood Pressure Cuff
- Pulse Counter
- Stethoscope
- Sleep Disorder Monitors
- Respiratory Air Flow
- Isokinetics
- Patient Bed Monitor

Ultrasound

- Near Field Imaging
- Prostate
- Transdermal
- Transluminal
- Coronary Arterial
- Breast
- Lithotripter
- Hydrophone Calibration Probes

Handicapped Aides

- Switches
- Braille Reader
- Hearing Aid
- Speech Intensification

Implantables

- Pacemaker Activity Monitor
- Implantable Switch
- Vascular Graft Monitor
- Micropower Source

Instrumentation

- Intravenous Drop Counter
- IV Air Bubble Detection
- Laser Switch/Modulator

AUTOMOTIVE

- Accelerometers
- Occupancy Seat Sensor

Switches

- Passenger Compartment Switches
- Horn Switch
- Control Panel

Fuel Level, Tire Rotation, Security

- Keyless Entry
- Motion (Theft) Sensor

CONSUMER

Musical Instruments

- Piano Keys
- Pick-up
- Drum Trigger

Sports Equipment

- Target Location
- Reaction Time
- Foul Line
- Force (Karate, Impact)
- Sweet Spot

Toys/Games

- Switches
- Proximity (Air Ranging Ultrasound, Pyro)
- Novelty Speakers (Microphones)
- Target Scoring

Audio

- Tweeter
- Balloon Speakers
- Novelty Speakers (Visor, Poster)
- Microphone
- Speaker distortion Feedback Accelerometer

Appliance

- Washer Imbalance
- Vacuum Soil Sensing
- Dishwasher Spray Arm
- Level Sensing Switches

MILITARY/GOVERNMENT

Hydrophones

- Towed Cable Array
- Hull Mounted Arrays
- Sonobuoys
- Active Noise Suppression

Ballistics

- Safety and Arming Fuses
- Shock Wave Gages
- Seismic Accelerometers

Physical Security

- Perimeter Security Cable (Buried or Fence)
- Seismic/Geophones
- Covert Microphones

Traffic Sensors

- Vehicle Classification
- Weight-In-Motion
- Speed, Red Light Enforcement
- Lane Designation
- Toll Booth

Appendix B - INDEX OF PIEZO FILM ARTICLES

[NOTE: THIS LIST IS ONLY A REFERENCE. COPIES OF THESE ARTICLES ARE NOT SUPPLIED BY MSI, INC.]

CODE	AUTHOR AND REFERENCE	TITLE
DEFOULING		
DF1	U.S Patent, 4,170,185 P.V. Murphy, M.J. Latour, Lectret S.A. (Switzerland) Oct. 9 1979.	Preventing Marine Fouling.
DF2	US DOD, Small Bus. Innovation Research Program; Ocean Power Technologies, Inc. Topic #DARPA 90-111	Piezoelectric Copolymer Antifouling System
ACTUATORS (Electromotional Devices)		
EM1	M. Toda & S. Osaka (RCA, Japan.) Proceedings of the IEEE.67(8). August, 1979.	Vibrational Fan Using the Piezoelectric Polymer PVF2.
EM2	M. Toda & S. Osaka (RCA Japan). Transactions of the IECE of Japan. 61(7). July 1978.	Electromotional Devices Using PVF2 Multilayer Bimorph.
EM3	M. Toda (RCA, Japan) Transactions of the IECE of Japan 61(7). July, 1978.	Design of Piezoelectric Polymer Motional Devices with Various Structures.
EM4	Gale E. Nevil, Jr. & Alan F. Davis. Paper from "Robotics Research: The next Five Years and Beyond". Aug. 14-16, 1984.	The Potential of Corrugated PVDF Bimorphs for Actuation and Sensing.
EM5	U.S. Patent, 4,666,198 Heiserman, David L., Microflex Technology.	Piezoelectric Polymer Microgripper.
EM6	Linvill, J.G. Stanford University. ©1986 IEEE	Piezoelectric Polymer Transducer Arrays.
EM7	Clive Robertson, Pennwalt (Europe) Application note.	Bimorph Drivers - An Electronic Solution.
EM8	M. Toda, K. Park, Atochem Sensors	Update on Novel Piezo Film Actuators and Ultrasound Transducers.
EM20	Amr M. Baz, Jeng-Jong Ro. Sound & Vibration, March 1994.	The Concept and Performance of Active Constrained Layer Damping Treatments
EM21	M. Sasaki, P.K.C. Wang, F. Fujisawa.	Stability Analysis of Piezo Polymer Flexible Twisting Micro-Actuator with a Linear Feedback Control.
EM22	US Patent 5,295,014, Minoru Toda	Two-Dimensional Laser Beam Scanner Using PVDF Bimorph.

EM23 Minoru Toda, Ferroelectrics, 1979, Vol.22, pp 911-918

Theory of Air Flow Generation By A Resonant Type PVF2 Bimorph Cantilever Vibrator.

FORCE TRANSDUCERS

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| F1 | G.R. Crane (Bell Labs, Holmdel) Transactions on Sonics and Ultrasonics. SU-25(6). November, 1978. | Poly(vinylidene)Fluoride Used for Piezoelectric Coin Sensors. |
| F4 | D.S. Leitner (Columbia U.) & M.C. Rosenberger (N.Y. Psych. Inst) Behaviour Research Methods and Instrumentation. 15(5). 1983. | A Simple and Inexpensive Startle Transducer with High Output. |
| F5 | U.S. Patent 4,282,532 R.G. Markham (Xerox Corp.) August 4, 1981. | Ink Jet Method and Apparatus Using a Thin Film piezoelectric Excitor for Drop Generation. |
| F15 | National Bureau of Standards NBSIR 76;1078. June 1976. | Piezo Polymer Transducers for Dynamic Pressure Measurements. |
| F17 | K.T. Park et al, IEEE 1986 International Symposium on the Applications of Ferroelectrics. | A charge Readout Algorithm for Piezo Force Transducers. |
| F18 | Seh-leh Chou et al. From Proceedings of the 1986 SEM Spring Conference on Experimental Mechanics. New Orleans, LA. June 3-18, 1986. | Interlaminar Normal Stresses in a Multilayered Plate -Theory and Experiment. |
| F22 | Scottish Schools Science Equip. Research Centre. January, 1987. | Electronic Balances using Kynar Piezo Film. |
| F27 | A.A.H.P. Megans, J. et al Janssen Pharmaceutica Psychopharmacology(1987)93: | Behavioral activity of rats measured by a new method based on the piezo-electric principle. |
| F30 | USA Patent 4,807,482. Kyung T. Park, Upper Darby; Richard D. Klafter, Wyncote, both of Pa. | Method and Apparatus for Measuring Stimuli applied to a Piezoelectric Transducer. |
| F32 | USA Patent 4,512,431. April 23 1985. | Weight Sensing Apparatus Employing Polymeric Piezoelectric Film |
| F35 | A. G. Bagnall, Harrow School, Harrow, Middlesex. UK | Investigations Using Piezo Film |
| F41 | A. J. Tuzzolino; Nuclear Instruments & Methods in Physics Research 00 (1991) NIM06317, North-Holland; Elsevier Science Purlibhsers B.N. | Two-dimensional position-sensing PVDF dust detectors for measurement of dust particle trajectory, velocity, and mass |

F42	D. A. Dillard, G. L. Anderson, D. D. Davis; 35th Sagamore Army Matls Res. Conf., Manchester, NJ June 26-30, 1988.	A Preliminary Study of the use of Kynar Piezoelectric Film to Measure Peel Stresses in Adhesive Joints
F43	Randy Fromm, RePlay Magazine, November 1991.	Gottlieb's System 3 Pinball
F44	W. Nitsche, M. Swoboda, P. Mirow, Berlin; Z. Flugwiss. Weltraumforsch. 15(1991) 223-226. Springer-Verlag 1991	Shock Detection by means of Piezofolios.
F45	W. N. Nitsche, P. Mirow, J. Szodruch, Berlin; Experiments in Fluids, Springer-Verlag 1991	Piezo-electric foils as a means of Sensing Unsteady Surface Forces
F46	Pieter de Bruyne, Laboratory for Communication Technology, Zurich, Switzerland; presented at International Graphics Symposium, Tempe AZ, Oct 27-30, 1993.	A Piezo-Electric Recording Device of Writing Velocity
F47	UK Patent, 2,235,802A; John Ronald Parks, National Research Development Corporation, London, 03-13-91.	Capturing Information in Drawing or Writing
F48	A.J. Tuzzolino, J.Z. Simpson, R.B. McKibben, H.D. Voss, H. Gursky. Adv Space Res., Vol 13, no 8, pp 133-136.	An Instrument For Discrimination Between Orbital Debris and Natural Particles In Near-Earth Space.
F49	A.J. Tuzzolino. Nuclear Instruments and Methods in Physics Research 1992.	PVDF Copolymer Dust Detectors: Particle Response and Penetration Characteristics.
FLOW		
FL1	Pennwalt News Release. May 1982	Piezo Film is key to Unique Flowmeter in New Perkin-Elmer Monitoring System.
FL4	Clive Robertson, Pennwalt Piezo Film Ltd. Edinburgh	The Use of Piezo Film for Sensing Fan Failure.
FL5	K. Sakai, Tokyo Gas Co, M. Okabayashi, Osaka Gas Co, Yasuda, Toho Gas Co.	Fluid Flowmeter - Gas Flowmeter Based on Fluidic Dynamic Oscillation.
FL8	Richard Brown, Pennwalt Piezo Film Ltd. Edinburgh, 7/23/90	Fuel Level Sensor using Multiple Transducers
FL9	E. J. Stefanides, <i>Design News</i> , p. 107; 7/23/91	Piezo Sensor Upgrades Wastewater Sampler's Accuracy
FL10	U.S. Patent 4,920,794 Ingman, 1988	Fluid Flow Meter
FL11	Richard Brown, Elf Atochem Sensors, Ltd., July 1992	Fuel Tank Level Sensor with Digital Output
FL12	Richard Brown, AMP Sensors EMEA	Discussion of Ultrasonic Ink Level Sensing

GENERAL

G6	M. Toda (RCA Japan). J.Appl. Phys. 51(9), September 1980.	Elastic Properties of Piezoelectric PVF2.
G15	Pennwalt Corporation. Material Safety Data Sheet. Nov. 15, 1986.KYNAR Piezo Film	
G19	U.S. Patent, 4,633,122 P.F. Radice (Pennwalt) Dec. 30, 1986.	Means for Electrically Connecting Electrodes on Different Surfaces of Piezoelectric Polymer Films.
G23	N.A. Suttle, Marconi Research Centre. GEC Journal of Research, Vol.5, No. 31987	New Piezoelectric Polymers
G24	Invention Record, Pennwalt Piezo Film Ltd., Edinburgh.	Forming mechanical and electrical connections to printed circuit boards.
G27	Francois Bauer, Lucien Eyraud Saint-Louis, France.	Ferroelectric Homopolymer PVDF and P(VDF-TrFE) Copolymers.
G30	Encyclopedia of Polymer Science and Engineering, Vol. 17, p. 532	Vinlydene Fluoride Polymers
G31	U.S. Patent 4,931,019, Kyung T. Park, 1 Sep 1988.	Electrostatic Image Display Apparatus
G32	Richard A. Ferren, Atochem Sensors, Inc. 1990	Polymeric Piezoelectric Transducers
G34	Steve Garrison, The Science Teacher, Feb. 92	Piezoelectric Film. . Investigate its Flexibility
G35	U.S. Patent 5,089,741, K. Park, F. Gastgeb, G. Daniels, Atochem Sensors, Inc. 1990	Piezo Film Impact Detector with Pyro Effect Elimination
G36	W. Campbell, Jr., J. J. Scialdone, Goddard Space Flight Center, Greenbelt, MD; NASA Reference Publication 1124 Revision 2	Outgassing Data for Selecting Spacecraft Material
G37	B.A. Auld (Stanford U.) & J.J. Gagnepain. J. Appl Physics. 50(8). August 1979.	Shear Properties of Polarized PVF2 Film Studied by the Piezoelectric Resonance Method.
G38	Nicola A. Suttle	New Piezoelectric Polymers
G41	D. Clarkson, Maplin Magazine, Jan 1993, pp 36-39	Piezoelectric Technology
G42	D. M. Brown, B&D Insts & Avionics, Inc. Valley Center, KS. Sensors Expo Proc, 1991; pp 105A-1 - 105A-11	Applications of PVDF for Aircraft Sensors

G43	F. Bauer, St. Louis, FR; J. Simonne, Toulouse, FR; L. Audaire, Grenoble, FR. 8th IEEE Int'l Symp. on Applic. of Ferroelectrics, Greenville, SC, Aug 31- Sep 2, 1992	Ferroelectric Copolymer and IR Sensor Technology applied to Obstacle Detection
G44	US Patent 5,424,716. Kyung Park	Penetration Detection System
G45	Joseph Dougherty. Penn State Mat'l Research Lab Report	PVDF Copolymer - Piezoelectric Powder Composites.
G46	Ken Turner. Schaumburg High School	Smart Sensors Module Report
G47	Glen MacGibbon. Appliance Engineer	Piezo Film Sensors For Appliance Applications.
G48	M.G. Broadhurst, G.T. Davis, J.E. McKinney, R.E. Collins	Piezoelectricity & Pyroelectricity in PVDF-A-Model

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H1	T.D. Sullivan & J.M. Powers (U.S. Navy). J. Acoust. Soc. Am. 63(5). May 1978.	Piezoelectric Polymer Flexural Disk Hydrophone.
H3	B. Woodward & R.C. Chandra (EE Dept., Lonborough U of Tech.) Electrocomponent Sci & Tech. 5. 1978.	Underwater Acoustic Measurements on Polyvinylidene Fluoride Transducers.
H4	Powers (U.S. Navy). Naval Underwater Systems Center, New London, CT 06320	Piezoelectric Polymer - An Emerging Hydrophone Technology.
H6	R.H. Tancrell, D.T. Wilson, D.T. and D. Ricketts, Raytheon Research Division.	Properties of PVDF Polymer for Sonar.
H8	J.M. Powers (U.S. Navy).	Long range Hydrophones.
H10	M. A. Josserand and C. Maerfeld, Thomson-CFS, France.	PVF ₂ Velocity Hydrophones.
H11	David R. Fox, IEEE Journal of Oceanic Engineering, Vol. 13, No. 4, Oct. 1988	A Low-Density Extended Acoustic Sensor for Low-Frequency Arrays
H13	Atochem Sensors, Inc. 12/31/90	Piezoelectric Polymer Hydrophones
H14	Innovative Transducers Inc., 1990	PISCIS MS-4 Marsh/Swamp Hydrophone PISCIS MS-5 Marsh/Swamp Hydrophone PISCIS BC-4 Bottom Cable Hydrophone
H15	Gregory Kaduchak, Christopher Kwaitkowski, Philip Marstan. J. Acoustic Soc. Am. 97 (5) Pt 1, May 1995	Measurement and Interpretation of the Impulse Response For Backscattering By A Thin Spherical Shell Using A Broad-Bandwidth Source That Is Nearly Acoustically Transparent.

H16	Clayton Spikes, Christopher Clark. Sea Technology, April 1996	Whales 95 - Revolutionizing Marine Mammal Monitoring Technology
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I1	U.S. Patent 4,904,894 Henry et al. February 1990	Hail Sensor
I2	Joseph Paradiso, Craig Abler, Kai-yuh Hsiao, Matthew Reynolds	The Magic Carpet: Physical Sensing for Immersive Environments

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K2	Patent 4,234,813 Heishaburo et al. (Toray Ind) November 18, 1980.	Piezoelectric or Pyroelectric Polymer Input Element for Use as a Transducer in Keyboards.
K6	U.S. Patent 4,328,441. F.R.Kroeger & R.A. Norquist (3M) May 4, 1982.	Output Circuit for Piezo-electric Polymer Pressure.
K9	J.V.Chatigny, Atochem Sensors	Novel Switch Ideas Using Piezo pyroelectric Polymer films.
K10	U.S. Patent, 4,633,123. P.F. Radice (Pennwalt) Dec. 30, 1986	Piezoelectric Polymer Keyboard Apparatus.
K11	U.S. Patent, 4,975,616. K.T. Park	Piezoelectric Transducer Array.
K12	U.S. Patent, 5,315,204. Kyung Park	Piezoelectric Snap Action Switch.

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M1	H.Naono, T.Gotch, M. Matsumoto (Acoustic Research Lab, Japan).	Design of an Electro-Acoustic Transducer using Piezoelectric Polymer Film.
M2	G.M. Garner (Allen Clark Research Centre). Systems Technology. 27 November 1977.	A new Microphone for Telephone Handsets.
M3	Pioneer Electric Corp.	Electroacoustic Transducer with Piezoelectric High Polymer Films.
M5	J.F. Sear & R. Carpenter (Allen Clerk - UK). Electronic Letters. 11. 1975.	Noise-Cancelling Microphone using a Piezoelectric Plastic Transducing Element.
M6	Reihard Lerch (Darmstadt, FRG). J. Acoust. Soc. Am. 66(4) October, 1979	Electroacoustic Transducers using Piezoelectric Polyvinylidene fluoride Films.

M11	R. Lerch & G.M. Sessler. J. Acoust. Soc. Am. 76(4) April 1980	Microphone with Rigidly Supported Piezo Polymer membranes.
M15	I. Veit, Sennheiser Electronic Wedemark, Germany. Presented at 84th Convention of Audio Engrg Society, March 14, 1988	The Piezoelectric PVDF Film. Its properties and application in electroacoustic transducers.
M17	Edward F. Downs, Jr. NCSC IR415-89	Independent Exploratory Development Piezoelectric Diver's Microphone Development.

MEDICAL APNEA

MA2	UK Patent, 2,138,144, A J. Fraden, Timex Medical, USA 14 February 1984.	Cardio-Respiration Transducer.
MA5	D.DeRossi and P Dario University Pisa and NCR Institute, Pisa.	Biomedical Applications of Piezoelectric and Pyro-Electric Polymers.
MA6	F. Steenkeste and &. Moschetto et al. Lille, France.	An Application of PVF2 Fetal Phonocardiographic Transducers.
MA7	K. Kobayashi & T. Yasuda Tokyo Ins. of Technology.	An Application of PVDF Film to Medical Transducers.
MA8	D. Dario, D De Rossie, R. Bedini, R. Francesconi & M.G. Trivella, Pisa, Italy.	PVF2 Catheter-Tip Transducers for Pressure, Sound & Flow Measurements.
MA10	Sally L. Hope et.al. Park Lane Surgery, Woodstock, Oxford UK. Journal of Ambulatory Monitoring 1988, Vol. 1 no. 1, 39-51.	Validation of the Accuracy of the Medilog ABP non-invasive blood-pressure monitor.
MA11	J. Fraden, Journal of Clinical Engineering. Vol.13, No3, Mar-April 1988.	Applications of Piezo/Pyroelectric Films in Medical Transducers.
MA14	U.S. Patent, 4,690,143, E. A. Schroepfel, Miramar, FL, Jan. 24, 1986	Pacing Lead with Piezoelectric Power Generating Means
MA16	D. Cavaye, M. Tabbara, G. Kopchok, R. White. Harbor-UCLA Med Ctr. Presented at So Cal Vascular Surgical Society Annual Scientific Mtg, Marina Del Ray, CA 9/91	Continuous Piezoelectric Pulse-Sensor Monitoring of Peripheral Vascular Reconstructions.
MA17	J. French, A. Siebens, Div of Rehab Medicine, Johns Hopkins Univ. Presented at RESNA 13 Annual Conf, Washington DC 1990	Interfacing Piezoelectric/ Pyroelectric Sensors for use with Communication Devices
MA18	C. K. McKibben, N. V. Reo, Dept of Chemistry, Kettering-Scott Magnetic Resonance Lab, Wright State Univ & Kettering Medical Center, Dayton OH	A Piezoelectric Respiratory Monitor for In Vivo NMR

MA19	Medical Electronics Buying Guide. Sept 1994	Buyers Guide and Market Analysis
MA20	SBIR Research Proposal, Phase I Abstract	A Bilaminate Electronic Bioinductive Wound Seal.
MA21	Allen Zuckerwar, Robert Pretlow, John Stoughton, Donald Baker. IEEE Vol 40, No 9, September 1993	Development of a Piezopolymer Pressure Sensor for a Portable Fetal Heart Rate Monitor.
MA22	Chris Henry. July 1988	Vascucare Respiration Air Monitor (R.A.M.) Phase II, Engineering Report.
MA23	S. Chonan, Z.W.Jiang, Y. Tanahashi, M. Tanaka, Y. Suga	A Soft Palpation Sensor & its Application to Measurement of the Stiffness of Prostate Glands
MA24		North American Science Research Associates Inc. RESEARCH REPORT ON TOXICITY

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MO1	J.J. Ficat, R. Durroux et al (France). Univ Paul Sabatien	Osteogen material/Piezoelectric Polymer.
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MS4	Pennwalt Press Release. June 1985.	Virtuoso Qualities in Electric Violin Made Possible by New Transducer Material.
MS5	Pennwalt Press Release. July 1985.	Piezo Film Pickup puts "The Sound of Magic" in New Gibson Guitar Line.

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MU5	Toray Industries, Tokyo, Japan. Ind. publication.	Piezoelectric Polymer Transducers for High Resolution Ultrasound Imaging.
MU6	J. Callerame et al. (Raytheon) in 1978 Ultrasonics Symposium, J. DeKerk & B.R. McAvoy, Editors IEEE Cat. No. 78 1344-ISU.V	Comparison of Ceramic and Polymer Transducers for Medical Imaging.
MU7	N. Chubachi (Japan). Paper presented at Joint Meeting of the Acoustical Society of America and Acoustical Society of Japan (Honolulu, 1978).	Piezoelectric Polymer Transducer and its application to Acoustics.
MU10	Mark Schafer & Peter A. Lewin. IEEE Transactions on Sonics and Ultrasonics, Vol. SU-31 No 4. July 1984	The Influence of Front-End hardware on Digital Ultrasonic Imaging.

MU13	F.S. Foster et.al. Ultrasound in Med. & Biol. 9(2) 151-164 1983.	Breast Imaging with a Conical Transducer/Annular Array Hybrid Scanner.
MU16	Peter A. Lewin & Mark Schafer. Drexel University, Philadelphia, PA.	Piezoelectric Polymer Transducers for Ultrasound Dosimetry Application.
MU17	M. Platte.	A Polyvinylidene Fluoride Needle Hydrophone for Ultrasonic Applications.
MU18	C.T. Lancee, J. Souquet, H. Ohigashi and N. Bom, Fifth Symposium on Echo-cardiology, Rotterdam, 1983.	Ferroelectric ceramics versus polymer piezoelectric materials.
MU23	D.W. Fitting et al. IEEE Transactions on Ultrasonics, Ferroelectrics, vol. UFFC-34 No. 3, May 1987.	A Two-Dimensional Array Receiver for Reducing Refraction Artifacts in Ultrasonic Computed Tomography of Attenuation.
MU24	M. D. Shearer, F. S. Foster, University of Toronto.	A 100 MHz PVDF Ultrasound Microscope with Biological Applications.
MU25	Valerie P. Jackson, M.D. et al. RADIOLOGY, Vol. 159, No. 3, Pages 679-684, June 1986.	Automated Breast Sonography Using a 7.5MHz PVDF Transducer: Preliminary Clinical Evaluation.
MU26	L. F. Brown & D. L. Carlson. IEEE Trans. on Ultrasonics, Ferroelectrics & Freq Control. Vol.36, No3, May 1989.	Ultrasound Transducer Models for Piezoelectric Polymer Films.
MU28	Stephen W. Smith, Principle Investigator, ERC	Ultrasound Transducers
MU30	B. Granz, R. Holzapfel, G. Kohler, IEEE 1989 Ultrasonics Symposium	Measurement of Shock Waves in the Focus of a Lithotripter
MU31	P. A Contla, D. K. Das-Gupta, IEEE 1991	Ultrasonic Piezoelectric Transducer for Biomedical Applications
MU32	R. Goldberg, S. Smith, Dept. Biomedical Engrg, Duke Univ., Durham, NC; L. Brown, Atochem Sensors, Inc., Valley Forge, PA	In Vivo Imaging using a Copolymer Phased Array
MU33	L. F. Brown, PhD., Elect Engrg Dept, So Dakota St Univ; Presented at 1992 SPIE International Symposium on Optical Applied Science and Engineering, 7/21/92, San Diego, CA	New Developments in Piezoelectric Polymer Ultrasound Transducers and Transducer Systems

NON-DESTRUCTIVE TESTING

NDT1	R.Stiffler & E.G. Henneke, 11 (VPI). Materials Evaluation, 41. July, 1983.	Application of Polyvinylidene Fluoride as an Acoustic Emission Transducer for Fibrous Composite Materials.
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NDT4	Systems & Instrumentation Ltd. Pershore, Worcs, England.	Polymer Film Transducers.
NDT8	Lewis F. Brown, Ph.D. Pennwalt Corp., Valley Forge, PA. Presented at ASNT 1989 Fall Conference Oct 9-13 1989.	Piezoelectric Polymer Ultrasound Transducers for Nondestructive Testing.
NDT9	Lewis F. Brown, Ph.D. Pennwalt Corp., Valley Forge, PA. Presented at 7th Intl Symposium on Applic. of Ferroelectrics, June 6-8, 1990	New Ferroelectric Polymer Ultrasound Contact Transducers for Non-destructive Testing Applications
NDT10	Lewis F. Brown, Ph.D. Pennwalt Corp., Valley Forge, PA. Presented at 1990 Review of Progress in Quantitative NDE, July 15-20, 1990	Permanently Mounted Piezo Film Sensors for Structural Quantitative NDE
NDT11	Lewis F. Brown, PhD. Atochem Sensors, Inc. Valley Forge, PA. Presented at 1991 Review of Progress in Quantitative NDE, July 28-Aug. 2, 1991	PFS-Gap: A Large Area Ultrasonic Gap Profile Measurement System
NDT12	J. Bulteel, Sensor Review, Vol. 11 No. 3. 1991. pp. 23-24	Polymer Materials for Ultrasonic Transducers
NDT13	L.F. Brown, PhD. So Dakota St Univ, Brookings, SD; W.M. Sisson, United Technologies Res. Ctr, East Hartford, CT; C.P. Guerin, Elf Atochem Sensors, Valley Forge, PA. Presented at 1992 Conf on Review of Progress in Quantitative Nondestructive Evaluation, July 23, 1992, Univ of Cal-San Diego	Custom PVDF Transducers for Pulse-Echo Testing of Solid Rocket Motors for Detection of Propellant-to-Boot-Liner Unbonds
NDT14	L.F. Brown, PhD. So Dakota St Univ, Brookings, SD. Presented at 1992 IEEE Fall Ultrasonics Symposium, Oct 20-23, 1992, Tucson, AZ	Ferroelectric Polymers: Current and Future Ultrasound Applications
NDT16	Lewis Brown. 1992 IEEE 8th International Symposium	New Extremely Broadband Ferroelectric Polymer Ultrasound Transducers

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OP1	T. Sato, H. Ishida & Co. Ikeda (Japan). Applied Optics. 19(9).	Adaptive PVDF Piezoelectric Deformable Mirror System.
OP2	H. Ohigashi, R. Shigenari, & M. Tokota (Toray, Japan) Japan J. Appl. Phys. 14(7) 1975.	Light Modulation by Ultrasonic Waves from Piezoelectric Polyvinylidene Fluoride Films.
OP3	D. Broussoux & F. Micheron (France). J. Appl. Phys. 51(4). April, 1980.	Electro-optic and Elastoptic Effects in Polyvinylidene Fluoride.
OP4	T. Sato, Y. Ueda & O. Ikeda (Japan). Applied Optics 20(2). January, 1981.	Transmission-type PVDF 2-D Optical Phase Modulator.

OP5	S.A. Kokorowski (Hughes Research). J Opt. Soc. Am. 69(1) January, 1979.	Analysis of Adaptive Optical Elements Made from Piezoelectric Bimorphs.
OP6	R. Kashyap & P. Pantelis. Second Symposium on Optic Fibre Measurements, Oct. 13-14 1982	Measurement of Optical Fibre Absorption Loss: A Novel Technique.
OP7	P. D. DeSouza, M. D. Mermelstein, Applied Optics, Dec. 1, 1982.	Electric Field Detection with a Piezoelectric Polymer-jacketed Single-Mode Optical Fiber
OP8	H. Coufal (IBM) Applied Physics Letters. 44(1) January 1, 1984.	Photothermal Spectroscopy Using a Pyroelectric Thin-Film Detector.
OP9	U.S. Patent 4,748,366 George Taylor, Sept. 2, 1986	Novel uses of Piezoelectric Materials for Creating Optical Effects
OP10	H. Sasabe, T. Nakayama et al. (Japan). Polymer Journal 13(10). 1981.	Photovoltaic Effect in Poly(vinylidene fluoride)
OP11	A. Mandelis (Toronto) Chemical Physics Letters 108(4). July 13, 1984.	Frequency-Domain Photopyroelectric Spectroscopy of Condensed Phases (PPES): A New Simple and Powerful Spectroscopic Technique.
OP12	V. S. Sudarshanam, R. O. Claus, Fiber & Electro Optics Res Ctr, VA Polytechnic Inst & State Univ, Blacksburg, VA. Accepted for publication in Proc Optical Fiber Sensors '93) Firenze, Italy, May 1993.	Fiber Optic Polarization and Phase Modulator Utilizing a Transparent Piezofilm with Indium Tin Oxide Electrodes

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P5	K. Shigiyama & K. Miura (Matsushita Comm. Inds. Co., Japan). Presentation.	PVDF Infrared Detector and Microphone for Monitoring.
P7	U. Korn, Z. Rav-Noy & S. Shtrikman (Israel). Applied Optics 20(11). June 1981.	Pyroelectric PVF2 Infrared Detector Arrays.
P12	U.S. Patent 3,824,098 J.G. BERGMAN et al. (Bell Labs) July 16, 1974.	Pyroelectric Copying Device.
P17	L.E. Ravich. Electronic Imaging. June 1984.	Pyroelectric Infrared Detectors.
P19	Pennwalt Corporation	KYNAR Properties.
P24	H. Meixner, G. Mader, P. Kleinschmidt. Siemens Entwickl. - Ber. Bd.15(1986)Nr.3.	Infrared sensors based on the Pyroelectric Polymer Poly-Vinylidene Fluoride (PVDF).

P25	Microwatt Applications. Sea Cliff, New York. U.S.A.	Comparisons of Pyroelectric and Piezoelectric Properties and Manufacturing of Several Detector Materials for Military and Scientific Applications.
P26	Microwatt Applications. Sea Cliff, New York. U.S.A.	Motion Detection Systems with Pyroelectric IR Detectors.
P27	Alan P Doctor, Microwatt Applications Inc., Martin Rost, Servo Corporation.	Pyroelectrics for Smart Munitions.
P29	M. Hammerich and A. Olafsson, Physics Lab., HC Orsted Inst.	A Versatile, low-cost pyroelectric Laser Power Monitor for the 1mW to 50W range.
P30	Reinhard Freitag, Hans Meixner Siemens AG, Corporate Research and Development, Munich, West Germany.	PVDF Sensor Array for Human Body Detection.
P33	U.S. Patent 4,797,840 Jacob Fraden, Hamden, Conn. Jan 10, 1989	Infrared Electronic Thermometer and Method for Measuring Temperature
P34	Richard Brown, ASL; 14 Dec 1990	Thermal Detector
P36	M. Thompson, Atochem Sensors, Valley Forge, PA. Presented at the 1991 Sensors Conference, Chicago, IL	Advances in Passive Infrared Sensors Based on Pyroelectric Polymer Films
P37	Edward Tom, Atochem Sensors, Valley Forge, PA	Polymer Passive Infrared Design for Long Range Detection
P38	Edward Tom. SENSORS Sept 1994	Polymer Film Arrays in Pyroelectric Applications

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PW2	Hausler, E. & Stein L. Paper presented at Ocnas '85.	Hydromechanic-Electric Power Converter.
PW3	Richard Brown, Pennwalt (Europe). Appl. note.	The LED Report.
PW9	Richard Brown, ASL; 1 Jan 1991	Piezo Film Power Supply; Tyre Sensor
PW10	Richard Brown, ASL; 3 Mar 1991	Energy Generation Using Piezo Film
PW11	G.E. Taylor, J. R. Burns, OPT	Hydropiezoelectricity
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PW13	USA Patent 3,665,226. R. Sinker, G. Williams; (Hughes Aircraft) May 23, 1972	Electric Power Source

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APPENDIX C -- APPLICATION NOTES

INTRODUCTION

A loudspeaker is a transducer which transforms electrical signals into acoustic sound. Conventional speakers usually consist of a vibrating surface (called a diaphragm) and a driving unit which is, in most cases, a voice coil driven by a magnetomotive force or a piezoelectric ceramic actuator. In piezoelectric polymer speakers, the active driving element and the air-pushing diaphragm are combined into a single unit. Utilizing the piezoelectric effect of polyvinylidene fluoride (PVDF) material and the flexibility of the polymer film, a unique speaker can be formed from PVDF which vibrates under the stimulus of an AC electric field applied to the surface electrodes on the film.

There are two principal types of loudspeakers. The first uses a vibrating surface to radiate sound directly into the air. The second uses an acoustic element (a horn, e.g.) which is inserted between the diaphragm and the air. The direct radiator type is used most often in small radios, residential, and automotive stereo systems. The horn type is used in high fidelity systems, large sound systems for auditoriums and theaters, and outdoor music and PA systems. Here we will only discuss piezo polymer speakers for direct radiating systems. The uses and effects will be discussed in a separate application note.

SPEAKER STRUCTURE

An extremely crude speaker element can be created by simply hanging a sheet of piezo polymer film in air and applying an AC electrical signal. Sound will emanate from the film and its audio characteristics will vary as you flex and bend the film in different directions. Although this demonstrates basic operation, the performance is marginal and unpredictable at best. By controlling the shape of the film and the support structure of the mounting, a very acceptable speaker can be created.

Please refer to Figure 1. A simple speaker design consists of two parts. The first is the vibrating PVDF diaphragm and the second is the speaker enclosure and support structure. Because PVDF film is anisotropic in its surface piezoelectric parameters, it is important to orient the film properly in this design. The maximum displacement per volt applied is along the machine direction (or "1" direction) of the film. As such, the highest acoustic output is achieved when the machine direction is oriented in the length L direction. The width W is perpendicular to the machine direction and the total height of the speaker consists of the enclosure depth H_2 and the film height H_1 .

The function of the enclosure is to isolate the front side of the film from the rear side. The film is curved in one direction (the direction of highest piezoelectric activity) and clamped rigidly onto each end of the enclosure. The curvature of the film is maintained by the sides of the enclosure. When a voltage is applied to the film electrodes, it creates a mechanical strain in the film in both the normal direction and in-plane active direction. Because the film is very thin, the strain in the normal direction is negligible. However, the larger displacement caused by in-plane strains is converted to radial motion along the radius of curvature and perpendicular to the film surface.

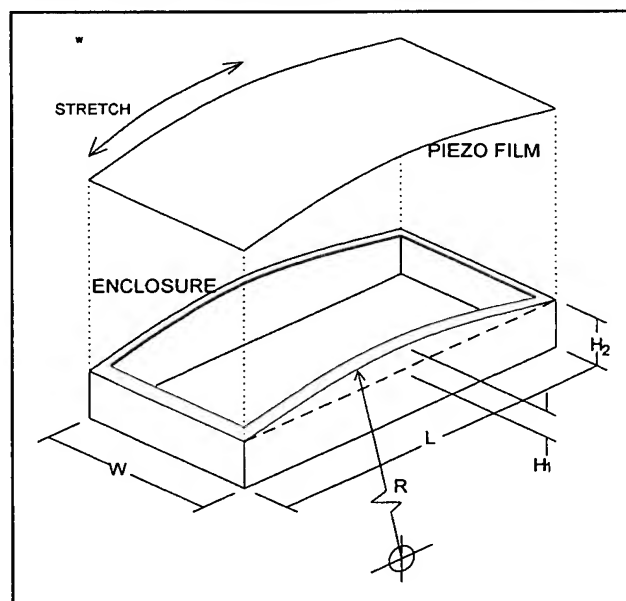


Figure 1

Because of the curvature, the film surface basically moves in and out of the enclosure. The large film area effectively couples acoustic energy into the surrounding air. This speaker design has very good high frequency characteristics. The acoustic output is constant for frequencies up to 20 kHz.

Sound pressure levels at a specified distance, and the frequency response curves of a piezoelectric polymer speaker can be analytically calculated by solving the wave equation for a curved plate in conjunction with the electro-mechanical equations of piezoelectricity.

The calculations involve the size and shape of the film element, amplitude of the driving signal, piezoelectric properties and dielectric and mechanical loss properties of PVDF film materials, radiation impedance effects, and the mass loading effects of the electrode materials, among other parameters. MSI has developed a computer program to obtain numerical results from a wide variety of parameters. Because of the complexities, the details of these calculations will not be presented here. Discussed below, however, are the effects of key structure parameters on the acoustic performance of a typical speaker design.

DESIGN PARAMETERS

PVDF FILM THICKNESS - Piezoelectric film is available in various thickness'. Standard thickness' from MSI are 28 μm, 52 μm, and 110 μm. Other thickness' are available on a special order basis. The sound pressure level produced by a piezo polymer speaker at a certain distance is directly proportional to the applied electric field strength. Therefore, for a given voltage, in principle, the thinner the film, the higher the sound pressure produced. Sound Pressure Level (SPL) is usually used to measure the output performance of a speaker and is defined by the following equation:

$$\text{SPL} = 20 \log_{10} \frac{P}{P_{\text{ref}}} \text{ (dB)}$$

P is sound pressure at a certain distance from the speaker and $P_{\text{ref}} = 2 \times 10^{-5}$ Pascal. Reducing the film thickness by half will generate a 6 dB increase in SPL. However, reducing film thickness will increase the capacitance of the speaker element, resulting in a higher current draw from the power amplifier (this will be discussed later). The use of thinner films can also cause deformation of the film curvature especially for speakers requiring large area of PVDF film. This deformation of curvature can cause irregularities in the frequency response curve.

CURVATURE OF PIEZOELECTRIC POLYMER FILM - The curvature radius of a film speaker is an important parameter for determining the frequency range of the speaker. For a rough estimation, the low frequency cutoff of a speaker is proportional to the square root of the ratio of Young's modulus of PVDF film to its density, and inversely proportional to the radius of curvature. Substituting the material property parameters, this low frequency can be estimated by the following equation:

$$f \sim \frac{21}{R(\text{cm})} \text{ kHz} = \frac{53}{R(\text{inch})} \text{ kHz}$$

R is the radius of curvature and f is the low frequency corner. See Figure 2. Note that the above equation does not take the mass loading effect of the electrodes into consideration. When the PVDF film is thin and heavy electrode materials such as silver ink are used, the above equation should be modified.

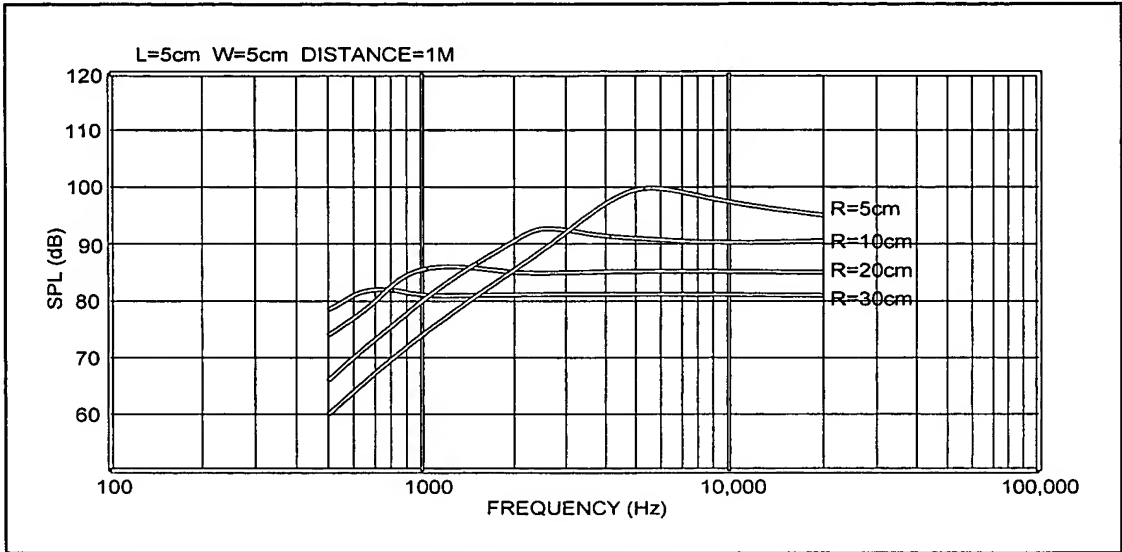


Figure 2

In the design of a piezo polymer speaker, the curvature of the film needs to be considered along with other structural parameters. For example, for a small area speaker, especially with a short length L, a large radius makes the film close to a flat plane, resulting in a lower acoustic output. On the other hand, for a large area speaker, a small radius makes the speaker deeper which requires a larger space.

Changing the radius not only controls the cutoff frequency, but also affects the sound pressure level at certain distances from the speaker. Figure 3a shows the relationship between low frequency corner and radius of curvature. Figure 3b shows the relationship between SPL at 10 kHz and radius of curvature for the same speaker. As seen from the graphs, the cutoff frequency and SPL are both inversely proportional to the radius.

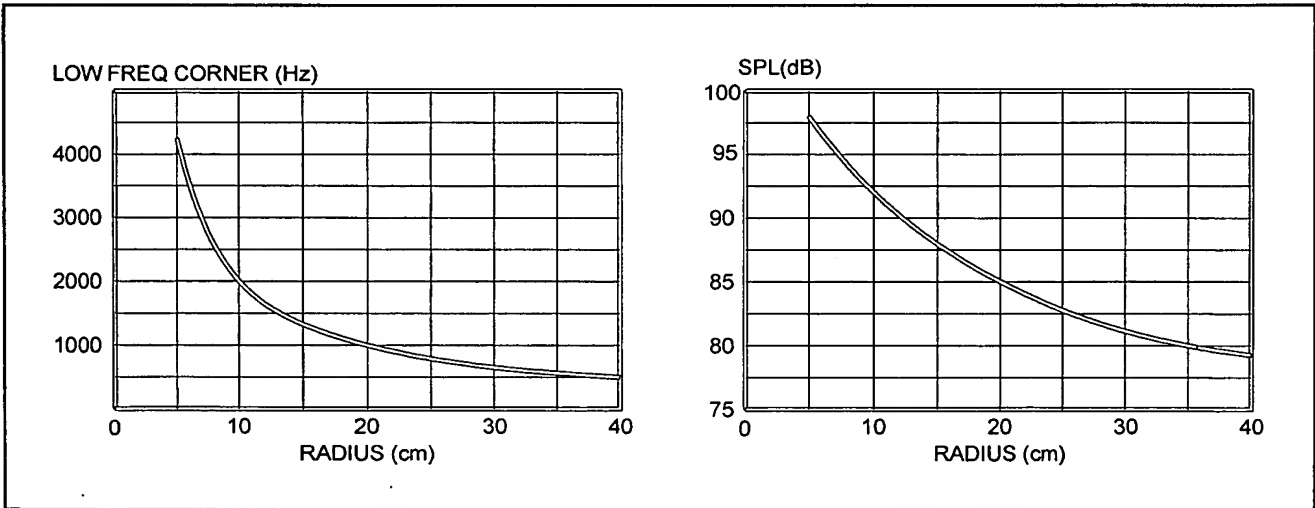


Figure 3a

Figure 3b

LENGTH AND WIDTH OF SPEAKER FILMS - The acoustic output of a PVDF speaker is directly related to the length and width dimensions which are, in turn, determined by each different application. The sound pressure generated by a speaker at a certain distance is linearly proportional to the active area of PVDF film. Therefore, SPL is a logarithmic function of the PVDF film dimensions if the speaker area is rectangular. Figures 4a & 4b show the relation between SPL and film length and width respectively at 10 kHz.

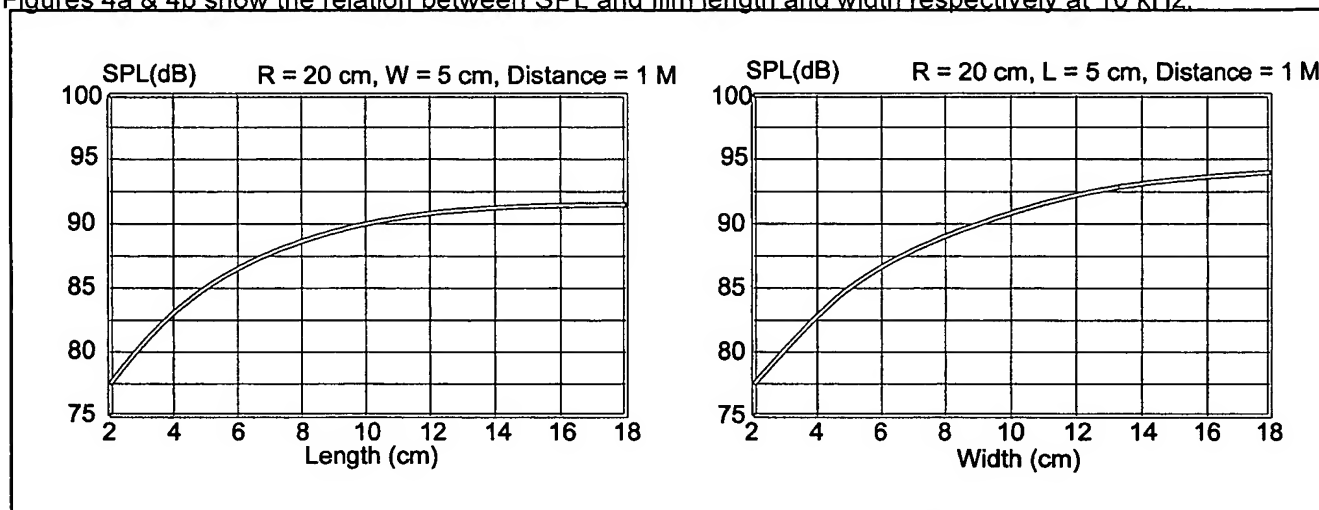


Figure 4a

Figure 4b

POWER CONSIDERATIONS

In order to obtain a significant displacement from PVDF film to radiate sound, a high voltage is usually required. A step-up audio transformer can be used to increase the output voltage of an audio amplifier. The designer should give consideration to the electrical properties of the PVDF film speaker and the capabilities of the audio amplifier when selecting or designing the transformer. The input/output voltage ratio is directly proportional to the primary/secondary turns ratio of a transformer:

$$\frac{V_{\text{sec}}}{V_{\text{pri}}} = - \frac{N_{\text{sec}}}{N_{\text{pri}}}$$

The primary/secondary impedance ratio is proportional to the square of the turns ratio. The transformer must have an output impedance that is equal to or less than the PVDF film impedance at the highest specified frequency. If these impedances are not matched, significant distortion may result.

Conventional speakers present a resistive load to the power amplifier output while a PVDF film speaker presents a capacitive load to the output. Because of this the piezo film speaker impedance changes with frequency. For a 28 μm thick film with an area of 10 cm X 10 cm, the typical capacitance is about 35 nF. In the high frequency audio range, the impedance of such a speaker is quite low resulting in a high current draw from the amplifier. This current is about 90 degrees out of phase with the voltage applied to the PVDF film. With the high applied voltage and large current at higher frequencies, the apparent power, defined as the transformer output current times the voltage applied to the PVDF film, is somewhat higher when compared to conventional speakers. This power issue needs to be considered when choosing amplifiers and transformers. Because of the capacitive nature of a PVDF film speaker, an electrical resonance is introduced when using a transformer. This resonance should be avoided within the frequency range of interest or carefully damped.

PRACTICAL DESIGN TIPS FOR SPEAKERS

A reasonably good tweeter can be made using the basic design shown in Figure 1. Keeping the film smooth and wrinkle free will reduce distortion and provide a flat frequency response. The support should also be as rigid as possible to maximize the film surface displacement.

The lead attachment area should not be on the PVDF film radiating surface because any non-uniformity in the radiating element can be a source for distortion of air cavity. Filling the enclosure with a sound absorbing materials such as fiberglass or absorbing foams will reduce resonances and improve the sound quality. The enclosure should be made as rigid as possible to reduce structural resonances.

APPLICATIONS AND ADVANTAGES

Piezoelectric polymer speakers can be made in just about any imaginable shape or size. Square or rectangular elements can be sized to fit any available space. Wide horizontal or vertical dispersion angles can be obtained by wrapping the film in a 180 degree or 360 degree shape. The film can form a stand alone speaker element or can be laminated or attached to other structures to become an integrated speaker. A single film held in a shape with different curvatures in different areas of the film can provide unusual and unique frequency response characteristics. Piezo film speakers have the advantages of flat frequency response, high sound quality, low weight, flexible form factor, low cost, and ease of manufacturability. PVDF film speakers have a wide range of applications including home stereo, home theater, automotive, personal stereo, multi-media, and stereo headphones.

SAMPLE SPECIFICATION

<u>PARAMETER</u>	<u>VALUE</u>
Frequency Range	3.5 kHz - 20 kHz
SPL @ 40 cm	105 dB +/- 5 dB
Drive Voltage	125 V _{rms}
Enclosure Dimensions	13 cm X 11 cm X 6 cm
Radius of Curvature	7 cm
PVDF Thickness	52 µm
PVDF Capacitance	24 nF

DISCUSSION OF ULTRASONIC INK LEVEL SENSING

Q: What is MSI's concept for detecting low ink level?

A: Right now, ink level in an ink-jet print cartridge can be measured using resistance (if the ink is partially conductive), or can be estimated by simply counting the number of droplets ejected. There are situations where neither approach will work – when the ink does not contain carbon, or where the cartridge is replaceable separately from the print head. MSI has based their approach on other work involving high-frequency ultrasound, and propose a kind of ultrasonic switch for each chamber of the cartridge. This "switch" would be a small patch of piezoelectric polymer, stuck onto the outside of the cartridge, which can send and receive an ultrasonic pulse into the wall. If the ink level is above the point where the patch is located, then most of the ultrasonic signal will travel on into the ink, and only a weak echo returns to the sensor. If the ink level is below the patch, then most of the signal returns, and the echo is strong. A simple voltage threshold is used to detect which condition exists.

Q: Sounds easy. What's the catch?

A: The basic principle is pretty straightforward, and has been demonstrated in the lab using electronics based on readily available discrete components. We know it has to be a low-cost solution, both for the sensor and the associated electronics. The integration of the electronics into an ASIC should be quite practical. The operating frequency of the device is high (about 20 MHz) and we need some gain (+40 dB seems likely) – but the development of mobile phones and high capacity hard disk drives has made this requirement seem quite realistic. Our biggest challenge is, quite simply, fixing the sensor onto the wall. If we don't achieve good consistency in this area, the sensor would not be reliable. It is unlikely that MSI will be doing this part of the assembly, so we need to work together to make sure that the process works.

Q: What about multiple chambers in a single cartridge? I'm interested in monitoring color cartridges.

A: Obviously, we could arrange separate sensors for each chamber. With our piezo film technology, this is easy since we can form independent patterns on a single piece of film. So an arrangement with three active signal electrodes, and a common ground, would work well – but this would require four contacts, and some multiplexing on the receiver amplifier input.

At this point, we began to think of ways to combine three sensors (for example) into a single, extended one, to simplify the interconnection and the associated electronics.

The obvious possibility is to treat the three separate walls as if they were one, allowing the three echoes to "add up" on arrival. If any one out of the three echoes were to increase in amplitude (as the ink level fell below the sensing point), we could detect this and flag the condition. This sounds fine until we consider the influence of tolerances on the echo amplitude. The basic piezoelectric coefficients of our material don't vary much along the length of a roll of film, but we would need to consider roll to roll variation, temperature influence on sensitivity, adhesive bonding variations, adhesive property temperature variations, wall tolerances on thickness and parallelism, and the variation of these with temperature.

Q: It's beginning to sound "risky". What is the basic signal/noise ratio?

A: Typically around +10 dB amplitude change, from ink to air on the inside of the wall. The precise value depends on the wall material, and slightly on the ink composition. But if we allow ± 3 dB on the starting level to cover all tolerance ranges, then add up three return echoes, we don't think we would have a very good "switch"!

That's why we exploited another concept we originally developed for a different kind of liquid level sensor – creating different path lengths for the ultrasonic signal for each chamber. This would simply be done by arranging fractional differences in the wall thickness of each chamber. This separates the three returning echoes so they arrive one after another, with approximately equal amplitude. We still have a tolerance associated with the amplitudes, but they don't add, and a single threshold should suffice to detect any one out of the three going "dry". The same principle applies for any number of chambers (within reason!).

Q: How much thickness change is required for each chamber?

A: Difficult to say, before we optimize many of the variables, but 0.2 to 0.5 Mr. & Mrs. steps look practical right now. So 1.0, 1.5 and 2.0 Mr. & Mrs. walls would certainly work – if necessary, the imbalance in internal volume could be made up by adding or subtracting material elsewhere in the chamber. The step size could be smaller, if we push for “perfect” ultrasonic waveform and possibly higher frequency.

Q: My cartridges have sponges inside. Will this affect the performance?

A: We believe not. It seems so far that a dry sponge looks just like air, and a wet sponge just like ink. It really is quite difficult to get good ultrasonic coupling at 20 MHz frequency, and the dry sponge simply lying in contact with the wall does not, as far as we can tell, absorb any of the ultrasonic energy at the interface. Even pushing a solid, flat block of polymer against the inside wall doesn't affect the signal unless a significant amount of force is applied, or liquid is allowed to penetrate into the gap.

Q: It sounds like the fixing of the sensor onto the wall is going to be quite a challenge!

A: The ideal case would be a very thin layer of liquid adhesive, which then cured to reach a hard state – epoxy works great! But we appreciate that a liquid process may not prove acceptable in production. We may be able to procure an off-the-shelf “transfer adhesive” (in tape form) which we can laminate to our film during our production cycle. Alternatively, we may need to enter into a dialog with a tape converter who could develop and apply a coating (with release liner) onto our film.

We envisage supplying reels of self-adhesive “labels”, kiss-cut to allow easy application onto cartridges.

Q: I understand the principle of the sensor. Now, how do we connect to this “label”?

A: We're working on this! One possibility is lightly-sprung contacts, which would be brought into contact only when the cartridge is at rest. Our electrode surface will be either sputtered metallization (around 500 Å thick) or printed silver ink (about 7 µm), so we don't think a wiping contact would be appropriate. Another possibility is capacitive coupling, if we can arrange some reasonable area of electrode surface (for both signal and ground tracks) to come into proximity with a similar arrangement fixed to the printer. There would be further signal losses, and probably additional tolerance variations, if this method were adopted. This is partly a cost issue – if we add too much area to the sensor just for capacitive coupling, the cost of this inactive area may jeopardize the economics of the whole solution.

The connection scheme also has to take into account the physical layout and practicalities of the printer itself. We can't design the solution in a vacuum – we need input from both the mechanical and electronic design teams responsible for the printer.

Q: Where should the interface electronics be located? Can I integrate these into an ASIC on the main pcb?

A: We think so. The sensor will be designed to have as low an impedance as practical at the operating frequency – ideally 50 ohms. Although we have, in theory, a small “antenna” connected to the gain stage, in practice we don't see noise pick-up as being a major problem. Shielded cable, or “gnd-sig-gnd” coplanar wiring would be preferred for carrying the signals over any significant distance within the printer. Our measurement process should only take a few microseconds, so it is possible that a “quiet time” (as far as intentional digital or control activity is concerned) could be selected to make the measurement. Noise radiation and immunity would need to be considered and reviewed throughout the design process.

Q: What control do I have over the “switching point”?

A: The placement of the sensor, of course, dictates the basic depth of ink where the “switch” will change state. Ideally, the active electrode area would be a narrow horizontal line. In practice, we prefer to use a rectangular element to increase the capacitance of the sensor (which allows better matching to practical electronics). The “switching point” will nominally occur at the vertical midpoint of the sensor. A “height” in the region of 5 to 10 Mr. & Mrs. appears likely for the overall “label”, so the lowest sensing depth may be 2.5 to 5.0 Mr. & Mrs. Temperature effects may vary the apparent location of this switching point, but worst-case uncertainty would be determined by the active electrode height.

Q: What factors would MSI wish to influence in my cartridge design?

A: The base material has an influence on the effectiveness of the solution. Some polymers (such as Nylon and acetyl) have high attenuation in the ultrasonic region. A close match of acoustic impedance

(speed of sound x density) to the ink would be preferred. Given several choices, we would evaluate and select the most favorable.

The wall thickness(es) have already been discussed, but it is also important to have the best possible parallelism at the sensing area. We appreciate that a finite draw angle is required for the moulding process, but if this can be minimized in the region of interest, then it makes our job much easier.

Smooth surfaces (outside and inside) work best – a spark-eroded on the outside surface would make ultrasonic coupling extremely difficult.

Q: I'm interested. How do we proceed?

A: We would split up the development effort into phases. Before commencing, we would seek to establish performance and economic targets for the solution, including timescales for the various stages of effort.

As a guideline, MSI would propose the following:

In Phase 1, MSI would build and supply concept demonstration units based on available cartridge samples, using discrete electronics. These units would not be qualified for temperature dependence or noise immunity, nor would the transducers or electronics be optimized, but they would serve as a discussion point when considering future effort. Basic performance would be documented in the form of a brief engineering report, together with candidate interconnection schemes and their characteristics.

Phase 2 would involve investigations into candidate adhesive systems and processing, study of temperature and other environmental effects on transducer performance, preparation of budgetary estimates for production equipment design and procurement, budgetary estimates of unit cost in production volumes. A series of prototype transducers would be supplied for customer evaluation and qualification.

A separate (perhaps parallel) effort may be required to qualify the selected interconnection scheme. This is highly dependent upon specific details of the printer design, and it is possible that this effort may best be performed by the printer manufacturer.

Phase 3 would lead towards product launch, including the design and procurement of production tooling.



Piezo Film Sensors

Product Guide and Price List

Measurement Specialties, Inc.

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P/N: 1005602-1 REV I

TYPICAL APPLICATIONS FOR PIEZO FILM SENSORS

Accelerometer

- ACH-01 (General Purpose)
 - Car Alarm
 - Shipping Damage
 - Machinery Monitoring
 - Motional Feedback for Speakers
 - Security Sensing
 - Appliance Monitoring
- ACH04-08 (Multi-Axis)
 - Disc Drive Shock Sensing
 - Impact Switching
 - Biomedical Monitoring
- Shockwriter 3000
 - Shipping Damage
 - Materials Handling
 - Machinery Monitoring

Vibration/Motion Film Sensor

- DT Series (Unlaminated, Unshielded)
 - Dynamic Strain Gages
 - Acoustic Pickups
 - Musical Instrument Triggers
 - Tamper Detection
- LDT Series (Laminated, Unshielded)
 - Antitheft Alarm
 - Vending
 - . Dispensing Verification
 - . Coin Drop Counters
 - . Antitamper
 - . Penetration Panels
 - Fan Failure
 - Appliance Monitoring
 - . Washer Imbalance
 - . Microwave - Sound Pickup
 - . Dishwasher Spray Arm
 - . Water Flow Sensor
 - . Vacuum Soil Sensing
- SDT Series (Unlaminated, Shielded)
 - Musical Instrument Triggers
 - Contact Microphones
- Custom Sensors
 - Textile Sensors
 - . Thread Break/Tension
 - Medical Monitoring
 - . Patient Bed Monitor
 - . Pulse Counter
 - . Fetal Heart Monitor
 - . Apnea Monitoring
 - . Anesthesia Monitor (Sleep Disorder)
 - . Respiratory Air Flow
 - . Sleep Disorder (REM)
 - . Pacemaker Activity Monitor
 - Earthquake Alarm

Switch

- SW100 Series
 - Pinball Impact Switches
 - Gaming Machine Switches
 - Utility Meter Counters
- Custom Switches
 - Vector Switch/Joystick
 - CMOS Circuit Wake-up Switch
 - Pacinko Game
 - Electronic Piano Keys
 - Impact Printer Timing Switch
 - Sports Scoring
 - . Karate Boxing Force
 - . Dartboard Scoring
 - Snap Action Switches
 - Beam Switch

Ultrasound

- Air-Ranging Proximity
- Medical Imaging Catheters
- Phased Array
- Non Destructive Testing
- Acoustic Emission
- Shockwave Sensors
- Level Sensors (Inkjet, toner)
- Robotic Tactile Sensors
- Variable Force Sensors

Audio/Acoustic

- Microphones
 - . Dive Helmets
 - . Gas Mask
 - . Contact
- Acoustic Pickups
- Flow Sensors
- Speakers
 - . Novelty Consumer
 - . Tweeters
 - . Pagers
- Hydrophones
 - . Navy SONAR
 - . Geophysical SONAR
- Active Vibration Damping/Noise

Traffic Sensors

- Series BL
 - Vehicle Classification
 - Weight-in-Motion
 - Speed/Red Light Enforcement
 - Airport Taxiway
 - Security/Safety

Piezo Cable

- Step Switches
- Pedestrian Mats
- Perimeter Security
- Antitamper

Power Supply

- Alternate Energy

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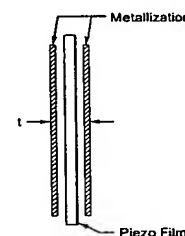
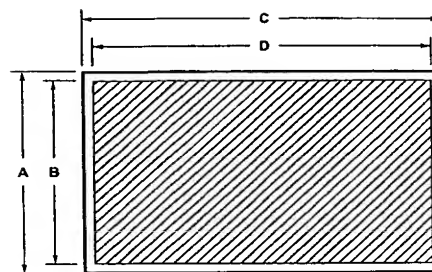
Metallized Piezo Film Sheets

Piezo film is available in a variety of different film sizes and thicknesses. These can be fabricated into simple transducers, or for use as full size sheets for applications such as speakers.

Metallization options include a compliant silver ink as well as sputtered metallization. The silver ink is best for applications where mechanical stress is being applied to the film. Thin sputtered metallization is brittle, and used where signal to noise requirements dictate very low mass loading by the electrodes. These are only general rules, and a discussion with our applications engineers will help you to make the best choice for your specific application.

Silver ink lends itself to custom metallization patterns for easy lead attachment. Our standard sputtered metallization is a nickel copper alloy, which has good conductivity and is resistant to oxidation. Other metallizations such as gold are available on a custom basis with a set up fee.

Piezo Film is available in different thicknesses. Thinner films (28 and 52 μm) are the most common, due to their higher capacitance and good mechanical qualities. Thicker film (110 μm) is used where maximum robustness is needed, or if the sensor is being used in a thickness mode (d_{33}) application.



DIMENSIONS in INCHES [mm]								Low Volume Price (US \$)
Description	A Film	B Electrode	C Film	D Electrode	t (μm)	Metallization	Part #	
28 μm piezo film	8.00 [203]	7.50 [190]	5.50 [140]	5.00 [127]	28	NiCu Alloy	1-1003703-4	\$55.00
28 μm piezo film	8.00 [203]	7.50 [190]	11.00 [280]	10.50 [267]	28	NiCu Alloy	1-1003702-4	\$110.00
28 μm piezo film	8.00 [203]	7.50 [190]	5.50 [140]	5.00 [127]	40	Silver Ink	1-1004347-0	\$55.00
28 μm piezo film	8.00 [203]	7.50 [190]	11.00 [280]	10.50 [267]	40	Silver Ink	1-1004346-0	\$110.00
52 μm piezo film	8.00 [203]	7.50 [190]	5.50 [140]	5.00 [127]	52	NiCu Alloy	2-1003703-4	\$65.00
52 μm piezo film	8.00 [203]	7.50 [190]	11.00 [280]	10.50 [267]	52	NiCu Alloy	2-1003702-4	\$130.00
52 μm piezo film	8.00 [203]	7.50 [190]	5.50 [140]	5.00 [127]	64	Silver Ink	2-1004347-0	\$65.00
52 μm piezo film	8.00 [203]	7.50 [190]	11.00 [280]	10.50 [267]	64	Silver Ink	2-1004346-0	\$130.00
110 μm piezo film	8.00 [203]	7.50 [190]	5.50 [140]	5.00 [127]	110	NiCu Alloy	3-1003703-4	\$75.00
110 μm piezo film	8.00 [203]	7.50 [190]	11.00 [280]	10.50 [267]	110	NiCu Alloy	3-1003702-4	\$150.00
110 μm piezo film	8.00 [203]	7.50 [190]	5.50 [140]	5.00 [127]	122	Silver Ink	3-1004347-0	\$75.00
110 μm piezo film	8.00 [203]	7.50 [190]	11.00 [280]	10.50 [267]	122	Silver Ink	3-1004346-0	\$150.00

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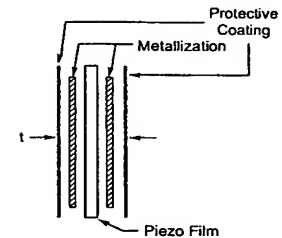
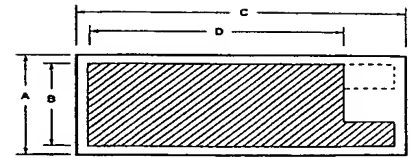
DT Series Elements

The DT series of piezo film sensors elements are rectangular elements of piezo film with silver ink screen printed electrodes. They are available in a variety of different sizes and thicknesses.

The DT film element produces more than 10 millivolts per microstrain, about 60 dB higher than the voltage output of a foil strain gage. The capacitance is proportional to the area and inversely proportional to the thickness of the element.

The DT series sensors are the simplest form of piezo film sensors, used primarily as dynamic strain gages and contact microphones for vibration or impact detection. These are available without any leads for those applications where the customer wants to make his own lead attachment. They can be readily adhered to a surface with double-sided tape or epoxy. Lead attachment can be achieved by compressive clamping, crimps, eyelets, conductive epoxy or low temperature solders.

DT elements are supplied with a thin urethane coating over the active sensor area; the lead attachment legs are free of the insulating urethane coating.



Dimensions in INCHES [mm]								Low Volume Price (US \$)
Description (No Leads)	A Film	B Electrode	C Film	D Electrode	t (μ m)	Cap (nF)	Part #	
DT1-028K	.64 [16]	.484 [12]	1.63 [41]	1.19 [30]	40	1.38	1-1002608-0	\$1.00
DT1-052K	.64 [16]	.484 [12]	1.63 [41]	1.19 [30]	70	.740	2-1002608-0	\$1.25
DT2-028K	.64 [16]	.484 [12]	2.86 [73]	2.42 [62]	40	2.78	1-1002145-0	\$2.00
DT2-052K	.64 [16]	.484 [12]	2.86 [73]	2.42 [62]	70	1.44	2-1002145-0	\$2.50
DT4-028K	.86 [22]	.740 [19]	6.72 [171]	6.13 [156]	40	11.00	1-1002149-0	\$4.00
DT4-052K	.86 [22]	.740 [19]	6.72 [171]	6.13 [156]	70	5.70	2-1002149-0	\$4.80

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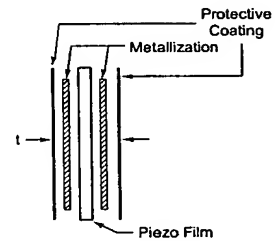
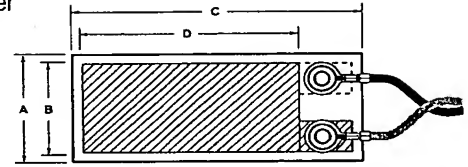
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DT Series Elements with Lead Attachment

The DT series of piezo film sensors elements are rectangular elements of piezo film with silver ink screen printed electrodes. They are available in a variety of different sizes and thicknesses.

Piezo film sensor elements are available with two lead attachment options. These include wires riveted to the film or wires attached to the film with eyelets. The eyelets offer holes at the lead attachment location to facilitate mounting.

The capacitance is proportional to the area and inversely proportional to the thickness of the element.



Dimensions in INCHES [mm]								Low Volume Price (US \$)
Description	A Film	B Electrode	C Film	D Electrode	t (μm)	Cap (nF)	Part #	
DT1-028K/L w/rivets	.64 [16]	.484 [12]	1.63 [41]	1.19 [30]	40	1.38	1-1002908-0	\$3.00
DT1-052K/L w/rivets	.64 [16]	.484 [12]	1.63 [41]	1.19 [30]	70	.740	2-1002908-0	\$3.25
DT2-028K/L w/rivets	.64 [16]	.484 [12]	2.86 [73]	2.42 [62]	40	2.78	1-1003744-0	\$4.00
DT2-052K/L w/rivets	.64 [16]	.484 [12]	2.86 [73]	2.42 [62]	70	1.44	2-1003744-0	\$4.50
DT4-028K/L w/rivets	.86 [22]	.740 [19]	6.72 [171]	6.13 [156]	40	11.00	1-1002150-0	\$6.00
DT4-052K/L w/rivets	.86 [22]	.740 [19]	6.72 [171]	6.13 [156]	70	5.70	2-1002150-0	\$6.80

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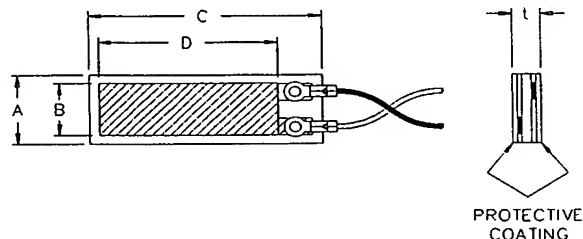
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LDT Series Elements with Lead Attachment and Lamination

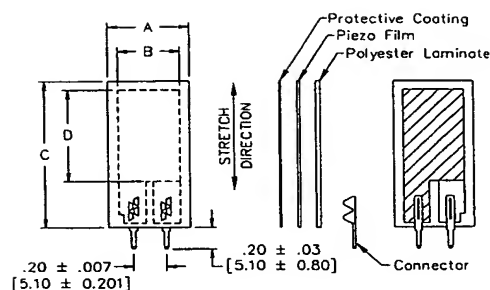
The 'L' in LDT stands for 'laminated' sensor. Typically, a 0.005" (125 μm) polyester layer is laminated to a 28 μm or 52 μm piezo film element. When used in a 'bending' mode, laminated film elements develop much higher voltage output when flexed than non-laminated (i.e., DT series) elements. The piezo film is off the neutral axis in the laminate, and is strained more when flexed. Applications



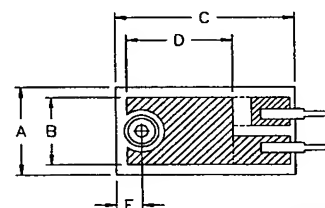
LDT Series with rivets and wire leads

for this include beam-type vibration sensors for vehicle alarms and solid state switches for counters and momentary contact closure type switches. Piezo film sensor LDT elements are available in a variety of lead attachment options. The LDT0-028K has crimped-on pins, 0.200" on center, suitable for soldering. For significantly increased sensitivity, the LDTM-028K (M-Mass) combines an LDT0-028K form factor with the addition of a .72 gram round mass (located E (.14") from the edge on the opposite side of the crimps in the center of the A (.26") dimension.) The LDT1, 2 and 4 have 12" of 26 gauge twisted pair wire. The capacitance is proportional to the area and inversely proportional to the thickness of the element.

The LDT0-028K and LDTM-028K with solder tabs can be soldered directly to a PCB with a reasonable level of care. Piezo film cannot withstand high temperatures ($> 80^{\circ}\text{C}$), and therefore soldering of the pins to a PCB must be done quickly. A heatsink clamped to the interface area between the film and the crimps will take the heat away from the film. Pre-tin the PCB and then quickly solder the sensor to the board. Do not allow the soldering iron to touch the film, and do not use a dwell time of over 5 seconds on the pins. Low temperature solders can also be used. For tightly toleranced sensitivity requirements, please consult MSI Sensors for techniques used to control variations of boundary conditions in production. Detailed specification sheets are available from our website.



LDT0-028K (with crimped-on solder tabs)



LDTM

Dimensions in INCHES [mm]								Low Volume Price (US \$)
Description	A Film	B Electrode	C Film	D Electrode	t (μm)	Cap (nF)	Part #	
LDT0-028K/L w/crimps	.520 [13]	.400 [10]	.980 [25]	.580 [15]	205	.500	0-1002794-0	\$.75
LDT1-028K/L w/rivets	.640 [16]	.484 [12]	1.63 [41]	1.19 [30]	205	1.38	1-1002910-0	\$2.50
LDT2-028K/L w/rivets	.640 [16]	.484 [12]	2.86 [73]	2.42 [62]	205	2.78	1-1003745-0	\$4.50
LDT4-028K/L w/rivets	.860 [22]	.740 [19]	6.72 [171]	6.13 [156]	205	11.0	1-1002405-0	\$7.50
LDTM-028K w/crimps	.520 [13]	.400 [10]	.980 [25]	.580 [15]	205	.420	0-1005447-1	\$1.00

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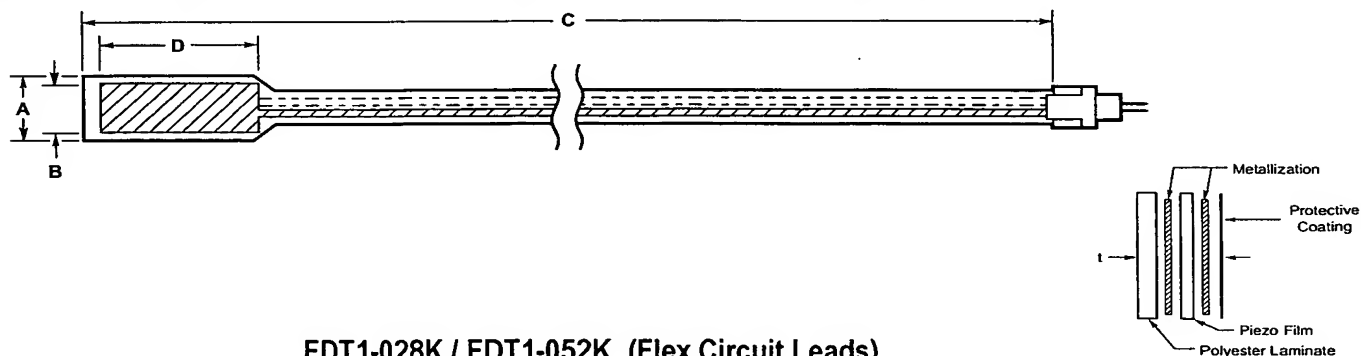
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FDT Series Elements with Lead Attachment

The 'F' in FDT Series stands for 'Flexible Leads'. These are rectangular elements of piezo film with silver ink screen printed electrodes. Rather than making the lead attachment near the sensor, the piezo polymer tail extends from the active sensor area as flex circuit material with offset traces. This gives a very flat, flexible lead, with a connector at the end.

The FDT elements are available in a variety of different sizes and thicknesses. They are available without a laminate (FDT), with a laminate (0.005" mylar) on one side (FLDT) or with tape release layer adhesive (FDT with adh) in the sensor area.



FDT1-028K / FDT1-052K (Flex Circuit Leads)

The connector pins on the FDT sensors can be directly soldered to a PCB with a reasonable level of care. This component cannot withstand high temperatures ($>80^{\circ}\text{C}$), and therefore soldering of the pins to a PCB must be done quickly. A heatsink clamped to the interface area between the film and the crimps will take the heat away from the film. Pre-tin the pins and then quickly solder them to the board. Do not allow the soldering iron to touch the film, and do not use a dwell time of over 5 seconds on the pins. Low temperature solder can also be used. The FDT is also available with a connector for insertion onto standard .025" square pins.

Dimensions in INCHES [mm]								Low Volume Price (US \$)
Description	A Film	B Electrode	C Film	D Electrode	t (μm)	Cap (nF)	Part #	
FDT1-028K	.620 [16]	.485 [12]	9.25 [235]	1.16 [30]	55	1.37	1-1002785-1	\$4.50
FDT1-052K	.620 [16]	.485 [12]	9.25 [235]	1.16 [30]	85	.740	2-1002785-1	\$5.00
FLDT1-028K	.620 [16]	.485 [12]	9.25 [235]	1.16 [30]	205	1.37	1-1002786-1	\$4.50
FLDT1-052K	.620 [16]	.485 [12]	9.25 [235]	1.16 [30]	230	.740	2-1002786-1	\$5.00
FDT1-028K w/adh-F	.650 [17]	.485 [12]	5.51 [140]	1.18 [30]	125	1.37	0-1001777-0	\$4.50

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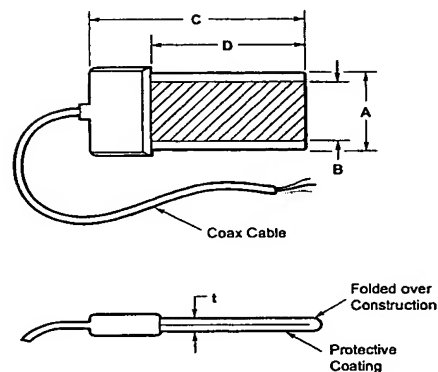
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SDT Shielded Piezo Film Sensors Element with Shielded Cable

The 'S' in SDT Series stands for 'Shielded Sensor'. SDT1 piezo film sensors consist of rectangular elements of piezo film together with a molded plastic housing and 18" of coaxial cable. The sensor area, screen printed with silver ink, is folded over on itself, giving a self-shielding of the transducer area. This is important in applications where 60 Hz EMI cannot be properly filtered, or in applications in a high EMI environment.

The SDT1 can be adhered to other surfaces using double sided adhesives, epoxy or cyanoacrylate (super-glue). Care should be taken if the sensor is to be removed, as the double-side adhesive can peel the metallization from the film.

When adhered to a surface in this manner, the SDT1 is an excellent contact microphone or dynamic strain gage. The output from the SDT1 can input directly to an oscilloscope or a signal analyzer. The low frequency roll off for the sensor is determined by the input impedance of the electronics. Typical impedances to be used would be at least 1 M Ω for most applications, and may need to be as high as 100 M Ω if 1-10 Hz frequencies are being monitored. Detailed specification sheets are available from our website.



Dimensions in INCHES (mm)								Low Volume Price (US \$)
Description	A Film	B Electrode	C Film	D Electrode	t (μ m)	Cap (nF)	Part #	
SDT1-028K	.644 (16)	.520 (13)	1.641 (41)	1.18 (30)	75	2.78	1-1000288-0	\$25.00

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Piezo Polymer Thick Film Elements

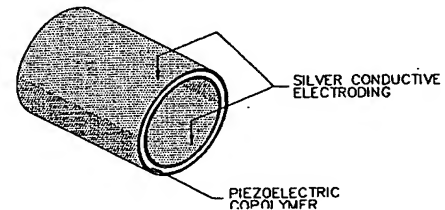
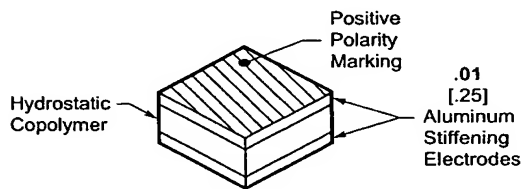
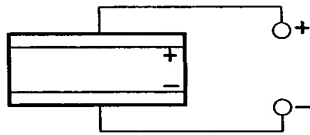
Piezo film has typically been available in thin film (9 – 110 μm) formats. These are useful thicknesses for most applications. Over the past few years, extensive research has been done to produce thicker films and non-standard shapes for those specialized applications where very high sensitivity is needed in the thickness mode (d_{33}) or for hydrostatic (d_{11}) measurements, like sonar.

MSI has developed thick film elements of piezo polymer. The standard building block for this is 500 μm material, which can be multi-layer stacked for increased sensitivity. As the thickness of the series stacked sensor increases, the sensitivity increases, but the capacitance decreases proportionately.

Additional stacking options are available on a custom basis for parallel wired configurations, where elements of film are laminated and wired to give a higher capacitance per unit of surface area. This option can also be used in order to create a shielded transducer, or an acceleration canceling device. The piezo polymer thick film elements can be provided with aluminum electrodes which clamp the in-plane piezo coefficients and therefore increase the hydrostatic sensitivity. These elements can be fabricated to customer specification, and can be made in sizes up to 12" x 18".

Thick piezo polymer can also be supplied in a cylinder format, with a wall thickness of 1.07 mm. The inner and outer walls are metallized with silver ink for electrodes. Wires can be affixed to these electrodes with conductive epoxy. Please specify the length dimension of the cylinder sensor when ordering.

Schematic:



Description	Dimensions		Capacitance pF/in ² [pF/cm ²]	Sensitivity (dB, re 1 V/ μPa)	Part No.	Low Volume Price (US \$)
	Polymer Thickness	Overall Thickness				
500S Tile	.020 [.51]	.040 [1]	88.90 [14]	-198.0	0-1001160-0	\$25.00/in ²
1000S Tile	.040 [1]	.059 [2]	44.40 [7]	-192.0	0-1001155-0	\$50.00/in ²
1500S Tile	.060 [2]	.079 [2]	29.60 [5]	-188.5	0-1001172-0	\$75.00/in ²
Cylinder	.047 [1]	Diameter .440 [11]	41 pF/in [16 pF/cm]	-195.0	0-1001911-1 (+) 0-1001911-2 (-)	\$25.00 each

NOTE: The (+) and (-) refer to the polarity

Please contact factory for custom part quotations and volume pricing.

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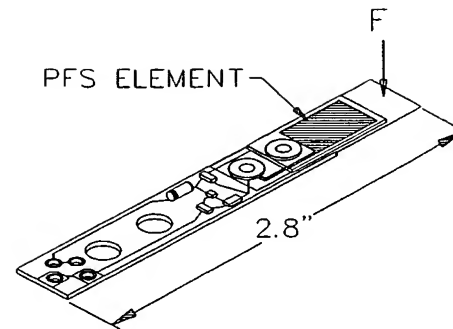
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Piezo Film Solid State Switches

Piezo film's capability to generate a high voltage output under bending strain, combined with its rugged form factor, make it an ideal candidate for solid state impact switches. Rather than using a switch contact closure, the piezo film generates a pulse which is detected by electronics. Although many of the DT's, LDT's and FLDT's supplied by MSI are used for switch applications, it is sometimes convenient to have a switch with integrated electronics.

The SW100 is an ideal configuration for impact detection and momentary switch applications. A direct contact force on the tip of the stainless steel cantilever beam of the SW100 induces strain on the laminated Piezo Film Sensor (PFS) element. With dynamic strain, the PFS element generates an output that activates a built-in, normally-open circuit. Once activated, the circuit resembles the closure of a contact switch, but without the inherent discontinuity that contact points exhibit because of corrosion, pitting and bouncing. Thus the SW100 provides a single digital pulse that is ideal for triggering digital circuits and signal processing. The imperviousness, elasticity and reliability of the PFS element, along with the noise rejection characteristics of the circuit, combine to provide the SW100 with features that suit applications demanding consistent, reliable performance throughout tens of millions of switching cycles.

Custom options are available to fit specific customer applications. For more information on the SW100, please call one of our applications engineers. Detailed specification sheets are available from our website.



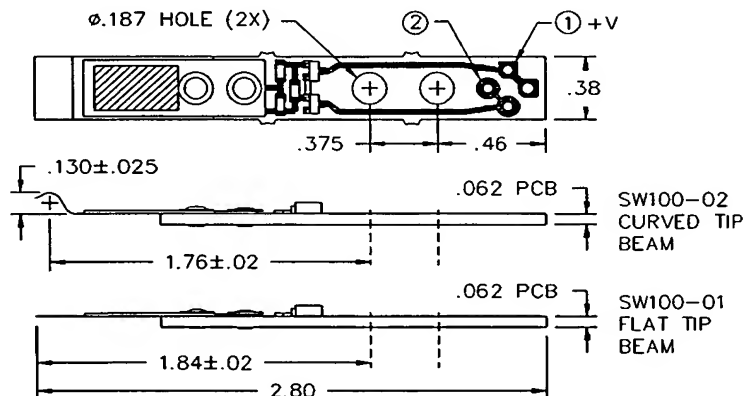
Smart Switch SW100

DIMENSIONS IN INCHES
TOLERANCES
2 PLACE DEC - $\pm .01$
3 PLACE DEC - $\pm .005$

RETURN STROKE
(BEAM RELEASE)



FORWARD STROKE
(FORCE INPUT)



Description	Beam Tip	Stroke Direction to Trigger Switch	Part #	Low Volume Price (US \$)
SW100-01-R	Flat	Reversed	0-1002393-1	\$5.00
SW100-01-F	Flat	Forward	0-1002393-2	\$5.00
SW100-02-R	Curved	Reversed	0-1002132-1	\$5.00
SW100-02-F	Curved	Forward	0-1002132-2	\$5.00

***Please contact factory for custom part quotations and volume pricing.**

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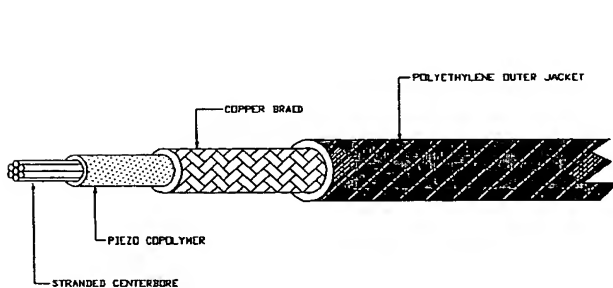
Piezo Polymer Coaxial Cable

Piezo cable is an alternative form of piezo polymer sensor. Designed as a coax cable, the piezo polymer is the "dielectric" between the center core and the outer braid. When the cable is compressed or stretched, a charge or voltage is generated proportional to the stress.

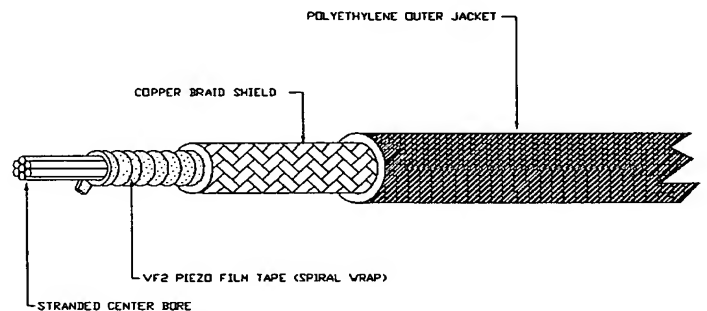
Piezo cable has a number of advantages in certain applications. Due to its coaxial design, the cable is self-shielded, allowing its use in a high EMI environment. The piezo cable can be spliced to passive coax, using standard coax splice techniques. It is extremely rugged, and will withstand repeated impacts. Its linear format makes it ideal for monitoring large areas which would be difficult and more expensive to do with piezo film.

Continuous lengths of piezo cable is available in a variety of different gages and construction formats. As a standard product, it is offered as a 20 AWG center core with a polyethylene outer jacket

We offer two versions of the piezo cable: copolymer and spiral wrap. Detailed specification sheets are available from our website.



20 AWG CABLE - COPOLYMER



20 AWG CABLE - SPIRAL WRAP

Description	Dimensions (Nom)		Capacitance pF/Foot (Nom) [pF/Meter]	Part No.	Price per meter (US \$)
	Center Core	Outside Dia.			
20 AWG Piezo Cable	.040 [1]	.107 [3]	200 [655]	0-1005646-1	\$16.50 (1-500 meters)*
20 AWG Piezo Cable - spiral wrap construction	.040 [1]	.105 [3]	279 [980]	0-1005801-1	\$12.50 (1-500 meters)*

***Please contact factory for custom part quotations and volume pricing.**

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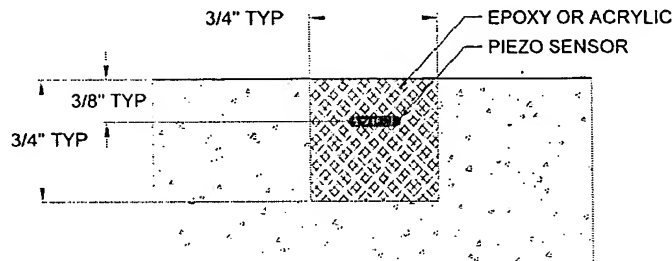
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Traffic Sensors

The Roadtrax BL Traffic Sensor is designed for Permanent or Temporary installation into or onto the road surface for the collection of traffic data. The unique construction of the sensor allows it to be installed directly into the road in a flexible format so that it can conform to the profile of the road. The flat construction of the sensor gives an inherent rejection of road noise due to road bending, adjacent lanes, and bow waves for approaching vehicles. The small cut in the road minimizes the damage that is done to the road, speeds up the installation and reduces the amount of epoxy that is used for the installation. The Roadtrax BL sensor is available both as a Class I sensor for the highest level of uniformity needed for Weigh in Motion applications and as a Class II sensor which is more cost effective for Counting, Classifying, High speed Toll Booths, Speed Detection, and Red Light Cameras.



Permanent In-The-Road Installation

- Uniform, high amplitude piezoelectric output compatible with existing counters and classifiers on the market.
- Excellent Signal to Noise Ratio which has an inherent 10:1 rejection of road noise due to road bending, adjacent lanes and bow waves of approaching vehicles.
- Easy installation in a 3/4" x 3/4" slot, which minimizes the disturbance of the road, decreases the depth of the road cut, and minimizes the amount of epoxy needed.
- Flexible sensor - conforms to any road profile while maintaining a uniform distance to the road surface.
- The final installation is flush with the road surface - snowplows will not do damage to the sensor.
- Durable enough to withstand normal installation handling and hundreds of millions ESAL's.
- All sensors are 100% tested and certified for performance as a complete sensor prior to shipment.
- Custom Passive Signal Cable with High Density Polyethylene Jacket which is rated for direct burial and resists nicks and cuts.
- Class II sensors are tested to $\pm 20\%$ uniformity; Class I (WIM) are tested to $\pm 7\%$ uniformity.

Description	Part #	Price (US \$) (Qty 1-49)
6' BL Class II w/100'	0-1005333-1	\$299.00
8' BL Class II w/100'	1-1005333-1	\$359.00
10' BL Class II w/100'	3-1005333-1	\$419.00
11' BL Class II w/100'	4-1005333-1	\$449.00
12' BL Class II w/100'	5-1005333-1	\$479.00
6' BL WIM	1-1005438-1	\$568.00
8' BL WIM	2-1005438-1	\$682.00
10' BL WIM	4-1005438-1	\$796.00
11' BL WIM	5-1005438-1	\$853.00
12' BL WIM	6-1005438-1	\$910.00
Extra Cable (50' increments only)	0-1004552-0	\$.50/ft

For additional information, request the BL Sensor Package, also available on our website.

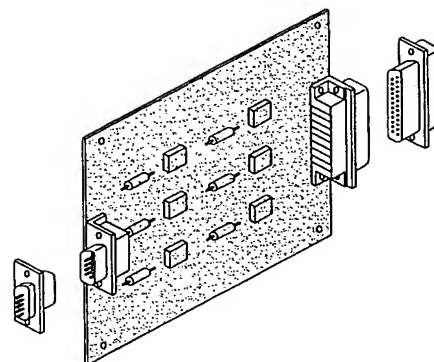
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Interface Circuit Board for Piezoelectric Traffic Sensor

The Traffic Sensor Interface Board is designed to condition signals from MSI's piezoelectric traffic sensors to interface with a wide variety of industry standard traffic data collection modules. The Traffic Sensor Interface Board contains six channel sensor signal conditioning circuitry, user adjustable comparator, digital pulse output, and internal power regulation. The Interface Board can be powered from a single supply voltage between +8VDC and +28 VDC.



SPECIFICATIONS

Number of input/output channels	6
Input (Analog)	9 Pin D type Male Connector
Output (Digital)	25 Pin D type Male Connector
Circuit Board Size	220mm x 128mm
Front Panel	50mm x 128mm
Storage Temperature	-40°C ~ +85°C
Operating Temperature	-40°C ~ +70°C

Output Connector Pin Assignment		Input Connector Pin Assignment	
Pin #	Assignment	Pin #	Assignment
1	GND	1	CH6
2	Power Supply	2	CH5
3	Not Used	3	CH4
4	Digital Output (CH1)	4	CH3
5	Digital Output (CH2)	5	CH2
6	Digital Output (CH3)	6	CH1
7	Digital Output (CH4)	7	GND
8	Digital Output (CH5)	8-9	Not Used
9	Digital Output (CH6)		
10-25	Not Used		

Description	Part #	Low Volume Price (US \$)
Interface Circuit Board for Piezoelectric Traffic Sensor	0-1005766-0	\$300.00

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Interface Circuit Board for Piezoelectric Traffic Sensor (cont'd)

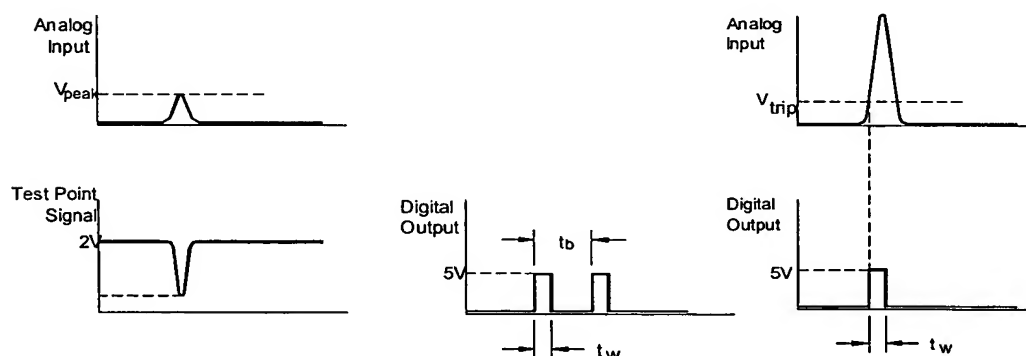
SPECIFICATIONS (cont'd)

Analog Circuit				
	Min	Typ	Max	Unit
Dynamic range	25		3V	mV
Gain		2		
Lower cutoff frequency (-3dB)		0.5		Hz
Upper cutoff frequency (-3dB)		1,200		Hz
Power Supply	+8		+28	VDC

Digital Output				
	Min	Typ	Max	Unit
Output Impedance			10k	ohms
Pulse output	4.5	5	5.5	V
Pulse width, t_w	2.8	3.3	3.8	ms
Black-out time, t_b	8.5	10.0	11.5	ms

Trip Level		
Dip Switch Position	V_{trip}	Unit
All Off	0.05	V
1 On	0.1	V
2 On	0.2	V
3 On	0.4	V
4 On	0.8	V

NOTE: V_{trip} indicates the sensor voltage output to trigger digital output.



NOTE: Test point signal has -2X gain and +2V DC offset.

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Accelerometers

The MSI family of accelerometers addresses a wide range of application needs. The ACH-01 is a general purpose, low cost, linear single axis accelerometer for a variety of monitoring applications. The ACH-04-08-05 is a multi-axis accelerometer, and the ACH-04-08-09 is a single-axis accelerometer, both with integrated buffer electronics designed for PCB mounting applications.

The MSI family of accelerometers have opened new doors to the design engineer who needs to continuously monitor vibration, shock and acceleration. Detailed specification sheets are available from our website.

MSI Accelerometers			
	Applications	Features	Benefits
ACH-01-XX	<ul style="list-style-type: none"> • Car alarms • Motion feedback for speakers • Integrated motor vibration monitor • Appliance vibration monitoring • Shipping damage recorder • Musical instrument pickups 	<ul style="list-style-type: none"> • Low cost • Very low power • Single axis • Wide frequency response • Large dynamic range • Small, lightweight • Buffered electronic output 	<ul style="list-style-type: none"> • High performance/price ratio • Low impedance output for simplified user interface • Very rugged to reduce failures • Ability to easily measure high frequency events • Low noise - High output
ACH-04-08-05	<ul style="list-style-type: none"> • Disk drive shock sensor • Appliance vibration monitoring • Automotive applications • Security sensors 	<ul style="list-style-type: none"> • Very low cost • Very low power • Multiple axis response, each as an independent channel • Small size - PCB mountable • Integrated buffer electronics • Low corner frequency 	<ul style="list-style-type: none"> • Exceptional performance at a very low cost • Buffered output lowers noise, reduces user interface electronics • Measures acceleration in multiple axes with only one sensor
ACH-04-08-09	<ul style="list-style-type: none"> • Car alarms • Appliance vibration monitoring • Security sensors • Low cost embedded applications 	<ul style="list-style-type: none"> • Very low cost • Very low power • Single axis • Integrated buffer electronics • Small size - PCB mountable • Low frequency response 	<ul style="list-style-type: none"> • Excellent performance at very low cost • Buffered output lowers noise, reduces user interface electronics • High sensitivity with very low power

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Accelerometers

Production Qualified Accelerometers				
		ACH-01-XX	ACH-04-08-05	ACH-04-08-09
Key Features		-Wide Frequency Range -Wide Dynamic Range -High Sensitivity -Low Noise -JFET Buffer	-Low Frequency Operation -3 Simultaneous Analog Outputs -Low current generation - JFET Buffer	-Low Frequency Operation -Low Current Operation - JFET Buffer
Sensitive Axes	X-Axis	---	X	--
	Y-Axis	---	X	X
	Z-Axis	X	X	--
Sensitivity (Nominal)		10 mV/g	1.8 mV/g	6mV/g
Frequency Range (± 3 dB)		1.0 Hz-20 kHz	0.5 Hz to 4 kHz	0.2 to 1500 Hz
Dynamic Range		± 250 g	± 250 g	± 40 g
Resolution (@ 100 Hz)		$40 \mu\text{g}/\sqrt{\text{Hz}}$	$200 \mu\text{g}/\sqrt{\text{Hz}}$	$40 \mu\text{g}/\sqrt{\text{Hz}}$
Resonant Frequency		>35 kHz	9.2 kHz	3.4 kHz
Resonant Q (Hz/Hz)		30	10	10
Transverse Sensitivity		5%	15%	<20%
Linearity		0.1%	0.1%	0.1%
Operating Temperature		-40 °C to +85 °C	-40 °C to +85 °C	-40 °C to +85 °C
Storage Temperature		-40 °C to +85 °C	-40 °C to +85 °C	-40 °C to +85 °C
Maximum Shock		1000 g	1000 g	1000 g
Supply Voltage		3 V to 40 V	3 V to 40 V	3 V to 28 V
Supply Current		2 μ A Typical	6 μ A Typical	2 μ A Typical
Weight		3 grams	0.35 grams	0.35 grams
Size (mm)		13 x 19 x 6	11 x 10 x 1.8	11 x 10 x 1.8
Mounting Method		Adhesive	Hand Solder to PCB	Hand Solder to PCB

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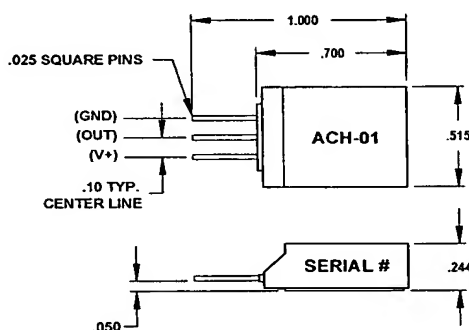
ACH-01 (General Purpose)

The ACH-01 is an inexpensive, very robust, general purpose accelerometer with outstanding performance characteristics. The use of KYNAR Piezo Film in the ACH-01 provides many cost/performance advantages that allow it to be used in a wide range of applications where the use of traditional accelerometer technology is impractical. It is specifically designed for high volume applications which require the permanent installation of an accelerometer, such as machine health monitoring, modal analysis, automotive sensors, appliances, and feedback control systems.

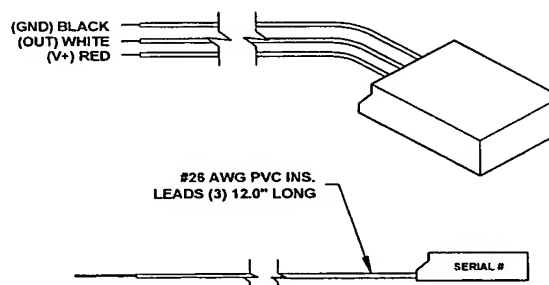
FEATURES

- Wide Frequency Response
- Excellent Phase Response
- Wide Temperature Range
- Wide Dynamic Range
- Small Temperature Dependence
- Low Cost
- Large Supply Voltage Range
- Excellent Linearity
- Low Impedance Output
- Very High Resonance
- Electrically Isolated Base
- Low Mechanical Q
- Low transverse sensitivity

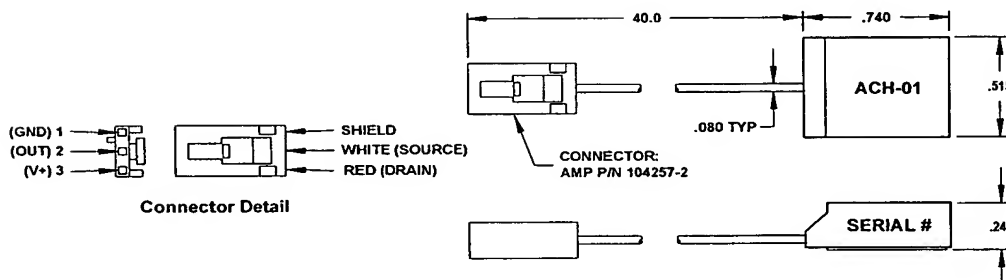
Note: All dimensions in inches and are reference.



ACH-01-02 with Pins



ACH-01-04 with Wires



ACH-01-03 with Shielded Cable

Please contact factory
for custom part
quotations and volume
pricing.

Description	Cable Configuration	Part #	Low Volume Price (US \$)
ACH01-02/10	3 Pins, .25" square	0-1000985-0	\$19.95
ACH-01-03/10	40" coax cable with female connector	1-1001220-0	\$19.95
ACH-01-04/10	Wires	1-1001497-0	\$19.95

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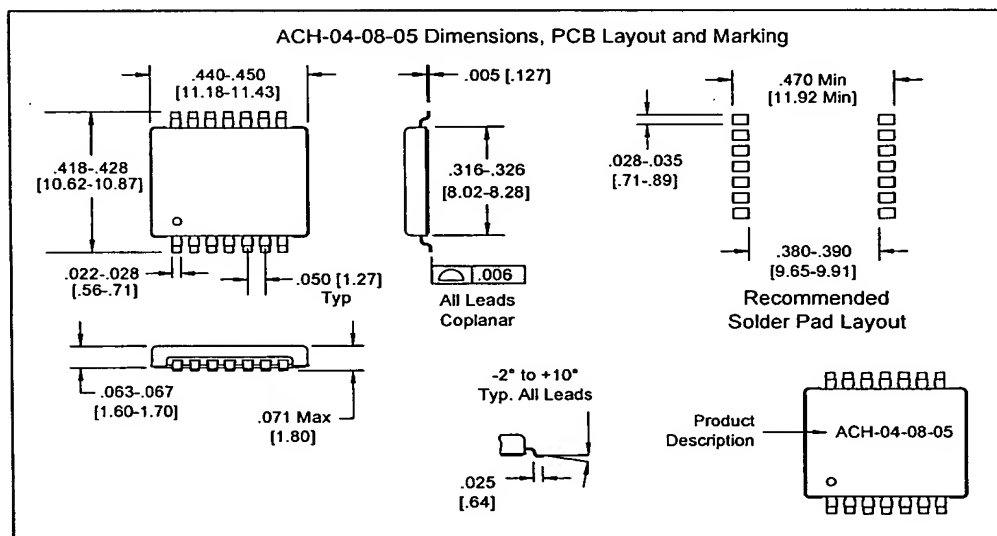
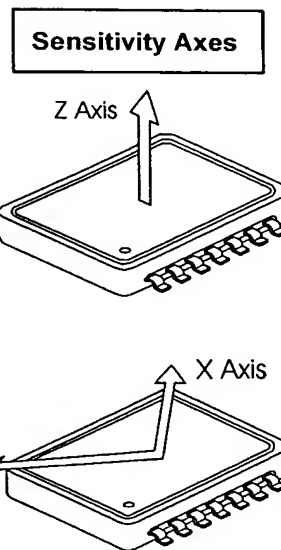
ACH-04-08-05 (Multi-Axis)

The ACH-04-08-05 accelerometer contains three piezoelectric sensing elements oriented to simultaneously measure acceleration in three orthogonal, linear axes. Internal JFET's provide for a low impedance, buffered output with a wide variety of possible, application specific, signal conditioning circuitry. The sensor responds over a broad frequency range, from below 0.5Hz to above 5kHz, as a result of the integrated electronics and the damped sensing elements.

The ACH-04-08-05 accelerometer can be used in a wide range of applications including motional measurement and control systems, speaker feedback systems, vibration switches, shipment monitor and material handling systems, security systems, computer input/output devices, and data loggers. The device is not IR reflow solderable.

FEATURES:

- Fully Contained 3-Axis Accelerometer
- Low Frequency Response
- High Resonant Frequency & Low Q
- Excellent Linearity
- Three Simultaneous Analog Outputs
- Low-Impedance Output
- Ultra-Low Power
- Low Cost



Description	Part #	Low Volume price (US \$)
ACH-04-08-05	0-1003800-5	\$25.00

Please contact factory for custom part quotations and volume pricing.

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ACH-04-08-09 (Single Axis)

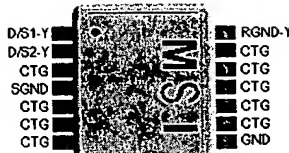
The ACH-04-08-09 accelerometer contains a single mass loaded piezoelectric sensing element oriented to measure acceleration in the plane of the device. An internal JFET provides for a low impedance, buffered output allowing a wide variety of off chip application specific signal conditioning circuitry. The sensor responds over a broad frequency range, from below 0.5Hz to above 2kHz, as a result of the integrated electronics and the damped sensing elements.

The ACH-04-08-09 accelerometer can be used in a wide range of applications including motion measurement and control systems, speaker feedback systems, vibration switches, shipment monitor and material handling systems, security systems, computer input/output devices, and data loggers.

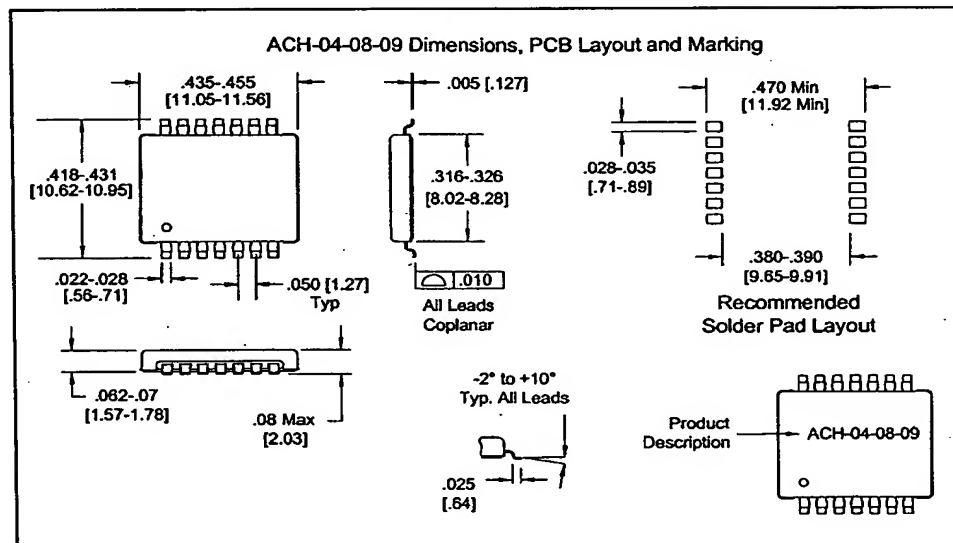
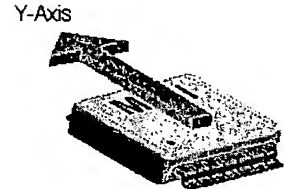
FEATURES:

- Fully Contained Single Axis Accelerometer
- Low Frequency Response
- Single Buffered Analog Output
- Low-Impedance Output
- Low Q at Resonance
- Excellent Linearity
- Ultra-Low Power (Typical I_o of 4mA)
- Low Cost

Pinout



Sensitivity Axis



Description	Part #	Low Volume price (US \$)
ACH-04-08-09	0-1005755-1	\$25.00

Please contact factory for custom part quotations and volume pricing.

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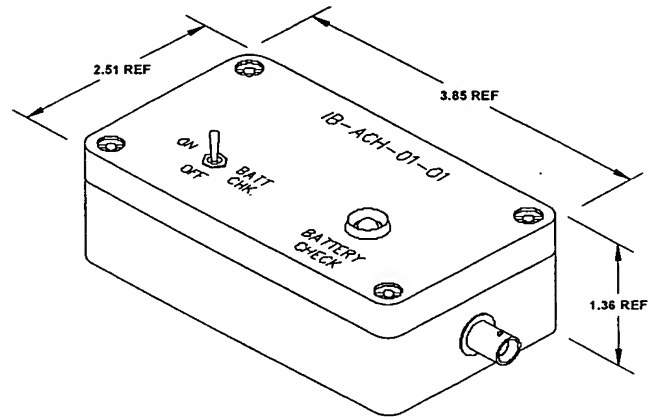
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IB-ACH01 (Amplifier Box)

MSI has developed this low cost interface amplifier specifically for use with the ACH-01. It is designed to mate directly to the connector supplied with the ACH-01-03 assembly. For use with either the ACH-01-02 or ACH-01-04, an adapter is required to interface the two components.

Characteristics	IB-ACH-01
Gain	10 X
Low Frequency Filter	-3dB @ 2 Hz, fixed
High Frequency Filter	-3dB @ 30 kHz, fixed
Power Supply	One 9 Volt Battery
Input Interface	FET for ACH-01
Supply Current	4.0 mA
Battery Life	80 Hours
Low Battery Cutoff	7.2 V
Output Impedance	100 Ω
Output Connector	BNC



Description	Part #	Low Volume Price (US \$)
IB-ACH-01	0-1003058-0	\$100.00

Please contact factory for custom part quotations and volume pricing.

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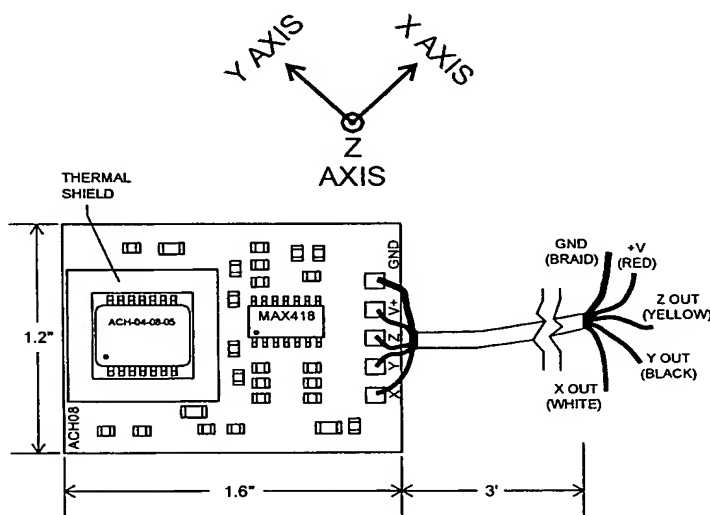
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ACH-04-08-05 Analog Test PCB

The ACH04-08-05 Accelerometer Analog Test PCB provides a simple way to evaluate the ACH-04-08-05 three-axis accelerometer. The unit consists of the ACH-04-08-05 accelerometer, a low-power operational amplifier, along with passive resistors and capacitors to provide signal conditioning. The sensor and circuit are preassembled on a double-sided, printed circuit board with three feet of flexible cable for easy user interface. The system demonstrates the basic capabilities of the ACH-04-08-05 accelerometer. Detailed specification sheets are available from our website.

FEATURES:

- Signal Conditioned 3-Axis Accelerometer
- High-Pass Filter @ 0.34Hz
- Low-Pass Filter @ 185Hz
- Requires Only Single +5V Power Supply
- Three Simultaneous Analog Outputs
- Low-Impedance Output
- Integrated Thermal Shield
- Ultra-Low Power (13 μ A @ 5V)



Description	Part #	Low Volume price (US \$)
ACH-04-08-05 Analog Test PCB	0-1005685-1	\$50.00

Please contact factory for custom part quotations and volume pricing.

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40kHz Omni Directional Ultrasound Transmitters 40kHz Wide Angle Ultrasound Receivers

Piezoelectric film (PVDF) ultrasound transmitters and receivers offer unique advantages for air ranging applications. Cylindrical 40kHz PVDF transmitters exhibit omni-directional horizontal beam directivity and broad band characteristics.

Cylindrical 40kHz PVDF receivers exhibit very wide horizontal beam directivity and broad band characteristics. These characteristics lend unique solutions in many applications such as two-dimensional positioning, digitizer, object detection, and distance measurement.

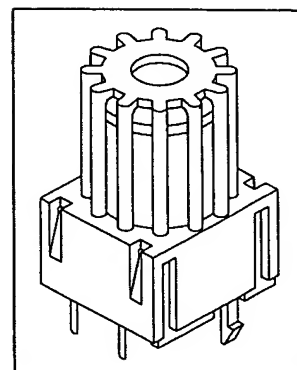
Depending on the applications, resonance frequency and vertical beam directivity of the transmitter and receiver can easily be customized by changing the diameter and length of the PVDF cylinder. The receiver has a very wide horizontal beam angle and it can be reduced by changing the housing design if necessary.

PVDF transmitters and receivers also have very low resonance Q value. Typically, PVDF transmitters have a Q value of 5 and PVDF receivers have a Q value of 4. This means that the rising time and the signal decay time are much faster than the conventional ceramic transmitters. This characteristic is suitable for high speed data acquisition or high speed digitizer applications.

A test board, consisting of snap-in mounting holes and test pins, is available for easy evaluation of the 40kHz transmitters. A preamplifier is available for easy evaluation of the 40kHz receivers.

FEATURES:

- Omni-directional horizontal beam directivity
- Broad band
- Low resonance Q
- Excellent impact resistance
- Low cost
- Light weight



Description	Part #	Low Volume Price (1 - 9) (US \$)
40 kHz <u>Transmitter</u>	1005853-1	\$10.00
Test Board (for <u>Transmitter</u>)	1005854-1	\$10.00
Drive Electronics (for <u>Transmitter</u>)	1005855-1	\$100.00
40kHz <u>Receiver</u>	1005856-1	\$10.00
Preamplifier Board (for Receiver)	1005857-1	\$25.00

Please contact factory for custom part quotations and volume pricing.

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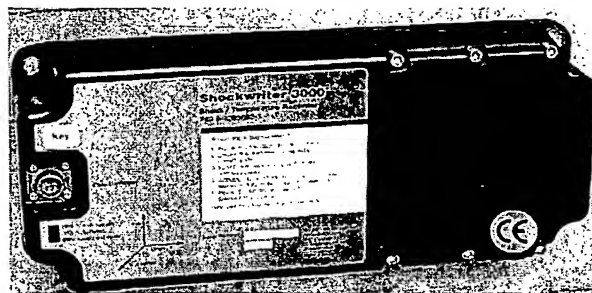
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• Shockwriter 3000®

The Shockwriter 3000 is a portable event recorder which monitors the environmental conditions during transportation and records specific events which exceed user defined standards. The combination of a triaxial accelerometer and thermistor provide the capability to accurately record vibration (shock) in any axes simultaneously as well as temperature. All recorded information is stored with the commensurate date including hour and minutes for easy possession tracking.

The unit is designed with a great deal of flexibility such that the end user can program the specific operating conditions based upon their specific application. The unit is easily programmed by a simple menu driven setup screen through an RS-232 serial interface port and a host computer (portable PC). In addition, the unit can be reprogrammed at any time in the future if the application or environmental conditions merit different monitoring thresholds.



Some of the specific operating parameters programmed by the end user include: temperature monitoring thresholds and intervals; acceleration thresholds and duration of event; sleep mode power conservation; data storage priority sorting and arming method. The most significant vibration events will contain additional information that will allow the user to graph the information (all three axes) or save it for further processing including signature analysis or statistical process control.

FEATURES

- Measures shock in three axes simultaneously, as well as temperature extremes, with commensurate date and time
- Password protected memory and setup configuration
- Permanent memory of data (even with loss or interruption of power)
- User friendly menu driven software programmed via RS232 port, DOS compatible or Windows95
- Lightweight (2.5lbs); slim profile
- Battery powered with long life power saving options
- Over 700 separate total events can be recorded
- Significant events can be easily graphed or transferred to more familiar software packages
- Fast software prevents Shockwriter from missing events
- Reusable for many different applications
- Affordable

For additional information, request the Shockwriter Catalog.

APPLICATIONS

- Continuation of ISO 9000 practices throughout transit
- Detection of events that may cause hidden damage (before installation begins)
- In-house materials handling / production monitoring
- Military hardware - certificate of transportation
- Aerospace hardware - certificate of transportation
- Insurance claim assistance
- Machinery monitoring
- Packaging optimization
- Air cargo quality
- International ocean transportation
- Railroad car coupling events

Description	Part #	Low Volume Price (US \$)
Shockwriter Kit (contains Shockwriter, software, power pack, data cable)	0-1005204-1	\$1,350.00
Data Cable (additional)	0-1005118-1	\$80.00
Power Pack (additional)	0-1005117-1	\$70.00

Measurement Specialties, Inc.

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Kits

A good way to learn more about piezo film sensors is to purchase one of our design kits. These kits illustrate the use of piezo film in different configurations, and are a good starting point to learn more about piezo film sensors and their applications.

Basic Design

This kit demonstrates the use of MSI piezo film sensors as microphones, speakers, switches and acoustic pickups. All the components and film samples in the kit can be used for experimentation.

Contents of the Basic Design Kit:

- ✓ Technical Manual
- ✓ Speaker Element
- ✓ Piezo Cable
- ✓ Flicker
- ✓ SW100-01-F
- ✓ ACH04-08-05
- ✓ SDT1-028K
- ✓ DT0-028K
- ✓ LDT1-028K
- ✓ DT1-028K
- ✓ Test PCB ACH-04-08 (w/o Analog circuit)
- ✓ Application Notes
- ✓ Application Specs
- ✓ Instruction Sheets

Piezo Cable

This kit features MSI piezo polymer in coaxial cable format. Piezo cable is especially useful for large area sensing applications such as physical security and safety mat sensors, proximity sensors, traffic sensors and security fence transducers.

Contents of the Piezo Cable Kit:

- ✓ Technical Manual
- ✓ Application Specs
- ✓ 20 AWG Piezo Cable spliced to RG-174/U with BNC Connector

Vibration/ Acceleration

This kit demonstrates the capabilities of piezo film as a vibration sensor and accelerometer component. The kit includes shielded and unshielded thin film sensors and an ACH-01 accelerometer component with an interface amplifier.

Contents of the Vibration and Acceleration Kit:

- ✓ Technical Manual
- ✓ SDT1-028K
- ✓ ACH-01 MSI Box
- ✓ ACH01-03/10
- ✓ LDT1-028K
- ✓ LDT0-028K
- ✓ DT1-028K
- ✓ 9 Volt Battery
- ✓ Application Specs
- ✓ Instruction Sheets

Description	Part #	Price (US \$)
Basic Design Kit	0-1004308-0	\$135.00
Piezo Cable Kit	0-1003726-0	\$75.00
Vibration/Acceleration Kit	0-1003460-0	\$189.00

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What You Should Know Before You Buy

ORDERING:

PHONE - Where and When to call

Call us direct at 610-650-1500 weekdays between 8 a.m. and 5 p.m. Eastern time zone. On the West Coast, please call 916-983-8644.

Have your purchase order number or VISA® /Master Card® number and expiration date handy.

FAX - Where and When to FAX

Fax us direct at 610-650-1509 anytime.

MAIL

Send your Company Purchase Order to:

Measurement Specialties, Inc.
Customer Service Department
P.O. Box 799
Valley Forge, PA 19482

MINIMUM ORDER \$100 (US Dollars)

SHIPPING:

Carriers

Products ordered through MSI are shipped from point of manufacture via ground carrier. Selection of carrier is based on weight and delivery location. Air freight is available at your request.

Shipping Charge

Shipping charges are prepaid and added to your invoice. You may request carrier charges be charged to your account.

PAYMENT:

Terms

Subject to credit approval, payment terms are net 30 days from invoice date. VISA and MasterCard are also accepted for payment.

PRICING:

Pricing

Prices in this catalog are in **U.S. DOLLARS**. These prices are valid through December 31, 2001.

Catalog Errors

Measurement Specialties reserves the right to correct printing errors and change prices without notice.

Taxes

We are required to collect all state and local sales/use taxes unless we have a tax exempt certificate on file.

RETURNS:

Before returning any item, please call to obtain a Return Material Authorization (RMA) from our Customer Service Department at 610-650-1503. This number will help us adjust your account as quickly as possible. We will ask for: the reason for the return, your purchase order number, date of purchase, and the MSI Order Number. Instructions for shipment will be given at that time.

MSI's QA department will analyze the returned goods and determine the cause of failure. If MSI confirms responsibility and the parts are in warranty, then appropriate credit or replacements will be sent.

TERMS & CONDITIONS OF SALE:

All orders are sold under the MSI Terms and Conditions of Sale.

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ORDER FORM

Order by FAX: (610) 650-1509 (Copy of Company P.O. MUST accompany your order)

Order by Phone: (610) 650-1503 Monday - Friday, 8:00 am - 5:00 pm EST

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Name _____

Company _____

Address _____

Phone () _____

☐ Is a confirming telephone order of (date) _____

☐ Bill Company P.O. (Copy must be attached)

☐ Check Enclosed ☐ VISA ☐ MasterCard

Exp Date _____

SHIP TO: (Please print) (DELIVERY TO STREET ADDRESS ONLY)

Name _____

Company _____

Address _____

Phone () _____

Card No. _____

Signature _____

Part #	Description	Quantity	Unit Price (US \$)	TOTAL (US \$)
Ordering Information: Delivery: From Stock Terms: 30 days net with approved credit SHIPPING: FOB Valley Forge, PA USA By UPS Ground or as specified by customer. Shipping and handling charges will be added to your invoice				
			Sales Tax	
			GRAND TOTAL (US DOLLARS)	

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Terms and Conditions of Sale

Measurement Specialties Incorporated, Sensors Division

- 1. Quotations and Acceptance:**
- (a) Quotations are valid for a period of sixty (60) days from date of quotation, and represent no obligation until Measurement Specialties, Sensors Division (hereafter MSI SENSORS) accepts the written Purchase order.
 - (b) In the event of inconsistency between MSI SENSORS' and the Purchaser's conditions, MSI SENSORS' shall prevail. No variation of MSI SENSORS' conditions shall be binding upon MSI SENSORS unless and until the variation has been accepted in writing by a duly authorized person on behalf of MSI SENSORS.
- 2. Price and Delivery:**
- (a) Unless otherwise agreed, Delivery will be F.O.B. MSI SENSORS' facility, Valley Forge, PA., and goods will be packed to MSI SENSORS' normal specification in nonreturnable packaging. Transportation will be arranged at the request and at the expense of the Purchaser. Where applicable, COD charges will be added to the price of the goods.
 - (b) Any delivery period quoted is an estimate only and commences from MSI SENSORS' acknowledgment of the Purchaser's order. The sole remedy of Purchaser for failure of MSI SENSORS to deliver in a timely manner shall be for Purchaser to acquire the goods from another source, in which case said quantity shall be eliminated from this contract, and Purchaser shall have no claim against MSI SENSORS for damages.
 - (c) MSI SENSORS reserves the right to deliver in more than one lot and to invoice each lot separately.
 - (d) Shortages, defective or damaged goods must be reported to MSI SENSORS within thirty (30) days of Delivery. All goods are shipped at Purchaser's risk and claims for goods damaged or lost in transit should be filed by the consignee direct with the transportation company.
 - (e) All returned materials must have a Returned Materials Authorization (RMA) number issued by MSI SENSORS. This authorization is valid for a period of 30 days. Returns at the customer convenience are limited to standard, catalog items, and are subject to a \$100 or 15% restocking fee, whichever is greater, excluding freight charges. Returned materials for Quality Complaints will be evaluated by the quality department and a credit issued when the complaint is approved. Customer specific products may not be returned except for Quality Complaints or MSI SENSORS.
 - (f) For all Customer Specific Products, MSI SENSORS reserves the right for a shipping tolerance of $\pm 5\%$ for each shipment and for the total order. Cancellation charges and/or inventory carrying costs may be imposed for products when orders are canceled or modified within eight weeks of the scheduled ship date.
- 3. Title and Risk of Loss:**
- (a) Title will pass to the Purchaser only on receipt by MSI SENSORS of payment for the full invoice price of the goods.
 - (b) Risk of loss shall pass to the Purchaser on leaving MSI SENSORS' premises.
- 4. Payment:**
- (a) Payment shall be due 30 days from date of invoice, subject to credit approval, except where MSI SENSORS stipulates CWO or COD terms. Payment shall not be withheld on account of any claim by the Purchaser against MSI SENSORS. MSI SENSORS reserves the right to charge interest at 1.5% per month on any sum outstanding after the due date.
 - (b) MSI SENSORS reserves the right, among other remedies, either to cancel this contract or to suspend further deliveries under it in the event Buyer fails to pay for any one shipment when payment becomes due. Should Buyer's financial responsibility become unsatisfactory to MSI SENSORS, cash payments or satisfactory security may be required by MSI SENSORS.
 - (c) Any tax, duty, custom, or other fee of any nature imposed upon this transaction by any federal, state, or local government authority shall be paid by the Purchaser, in addition to the price quoted or invoiced. In the event MSI SENSORS is required to prepay any such tax, Purchaser will reimburse MSI SENSORS.
 - (d) Unless specifically otherwise stated, all payments are to be made in United States Dollars (\$), with the payment check drawn on a US Bank. All banking charges, if any, are to be pre-paid by the Purchaser.
- 5. Technical Assistance and Data:** MSI SENSORS may, at Purchaser's request, furnish technical assistance, advice and information with respect to the goods supplied under this Contract, if and to the extent that such assistance, advice and information is readily available, except for proprietary techniques or procedures. It is expressly agreed that there is no obligation to provide such information, and that the information is subject to the limitation of liability in paragraph 10 below. MSI SENSORS accepts no liability in contract, tort or otherwise for any damages or injury arising directly or indirectly from any error or omission in such technical data or literature.
- 6. Warranty:**
- (a) MSI SENSORS warrants title to the product sold hereunder and that for a period of 90 days from Delivery it conforms to MSI SENSORS' specifications and is free from defects in material and workmanship. If the product fails to meet said warranties, MSI SENSORS shall replace or issue credit for the non-conforming product at no cost to Buyer. The foregoing is Buyer's sole and exclusive remedy for failure of MSI SENSORS to deliver or supply product that meets the foregoing warranties. **MSI SENSORS MAKES NO OTHER WARRANTY OF ANY KIND EXPRESS OR IMPLIED INCLUDING ANY WARRANTY OF MERCHANTABILITY, FITNESS OF THE PRODUCT FOR ANY PARTICULAR PURPOSE EVEN IF THAT PURPOSE IS KNOWN TO MSI SENSORS, OR ANY WARRANTY RELATING TO PATENTS, TRADEMARKS, COPYRIGHTS OR OTHER INTELLECTUAL PROPERTY.**
 - (b) Purchaser warrants that the designs and specifications furnished by it to MSI SENSORS will not infringe any patent, trademark or copyright with respect to the manufacture and sale of the resulting products.
- 7. Tools:** Tools made for the manufacture of goods to be supplied under the contract and the copyright therein remain MSI SENSORS' property notwithstanding that the Purchaser may have been debited with any sum in respect of their cost.
- 8. Excusable Delays:** No liability shall result from delay in performance or non-performance in whole or in part if performance as agreed has been made impracticable by compliance in good faith with any applicable foreign or domestic governmental regulation or order whether or not it later proves to be invalid, or by the occurrence of a contingency the non-occurrence of which was a basic assumption on which this contract was made, including, but not limited to, acts of God, fire, flood, accident, riot, war, sabotage, strike, labor trouble or shortage, or embargo. MSI SENSORS' inability to obtain at prices and on terms deemed by it to be practicable any required raw material, energy source, equipment, labor, or transportation, or any increased costs due to capital improvements for environmental protection shall also be sufficient to relieve MSI SENSORS of its obligation to perform hereunder. If any of such circumstances affect only a part of MSI SENSORS' capacity to perform, MSI SENSORS shall have the right to allocate production and deliveries among all of its customers and its own requirements in a manner and at such times as MSI SENSORS may determine. Quantities affected by this paragraph may, at the option of either party, be eliminated from the contract without liability, but the contract shall remain otherwise unaffected.
- 9. Indemnification:** Buyer agrees to indemnify, defend and hold MSI SENSORS harmless from and against that portion of any liability, cost, expense (including reasonable attorneys' fees), claim, judgment, settlement or damage that MSI SENSORS may be required to pay to any third party (including, but not limited to, any employee of Buyer who alleges or proves that he or she has been injured in the course of his or her employment while working with the products supplied by the MSI SENSORS under this agreement), which is caused or contributed to by the negligence or fault of Buyer; or ii) results from the infringement of any patent, trademark or copyright related to the products (or designs and specifications therefor) supplied to Buyer hereunder. In case the Buyer resells the products supplied by the MSI SENSORS under this agreement, Buyer will request and if possible obtain from its purchaser an indemnification similar to the foregoing for the benefit of Buyer and MSI SENSORS.
- 10. Limitation of Liability:** MSI SENSORS shall not be liable on contract, tort or otherwise for any loss or damage suffered by the Purchaser whatsoever or howsoever arising out of or in connection with the supply of goods or services by MSI SENSORS other than to supply goods conforming to the original agreed specifications or at MSI SENSORS' option to refund to the Purchaser any moneys already paid in respect of the goods. MSI SENSORS' liability with respect to this contract and the products purchased under it shall not exceed the purchase price of the portion of such product as to which liability arises and MSI SENSORS shall not be liable for any injury, loss or damage, resulting from the handling or use of the product shipped hereunder whether in manufacturing process or otherwise. **In no event shall MSI SENSORS be liable for special, incidental or consequential damages, including, but not limited to, loss of profits, capital or business opportunity; downtime costs; or claims of customers of Buyer.** Failure to give MSI SENSORS notice of any claim within 30 days of Delivery of the product concerned shall constitute a waiver of such claim by Buyer. Notwithstanding any applicable statute of limitations to the contrary, any action by Buyer relating to a claim hereunder must be instituted no later than two (2) years after the occurrence of the event upon which the claim is based. All of the foregoing limitations shall apply irrespective of whether Buyer's claim is based upon breach of contract, breach of warranty, negligence, strict liability, or any other legal theory.
- 11. Termination:** If the Purchaser commits any breach of the terms and conditions of the contract or suffers distress or execution or becomes insolvent or commits an act of bankruptcy or enters into any arrangement or composition with his creditors or goes or is put into liquidation (other than solely for amalgamation or reconstruction while solvent) or if a receiver is appointed over any part of the Purchaser's business, MSI SENSORS may without prejudice to any rights which may have accrued or which may accrue to it terminate the contract summarily by notice in writing.
- 12. Entire Agreement:** This agreement constitutes the entire contract of sale and purchase of the product herein named. It is not assignable by Buyer without the written consent of MSI SENSORS. No modification of this contract shall be of any force or effect unless in writing signed by the parties and no modification shall be effected by the acknowledgment or acceptance of purchase order forms containing different terms or conditions.
- 13. Governing Law:** This contract shall be governed by and construed in accordance with the laws of the Commonwealth of Pennsylvania. Any lawsuit brought by Buyer arising out of the transactions covered hereunder shall be instituted in the appropriate state or federal court located in Philadelphia County, Pennsylvania, and Buyer further submits itself to the jurisdiction of said courts in the event MSI SENSORS elects to institute any action in said courts.

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